MODEL G0675
10" JOINTER/PLANER COMBO MACHINE
OWNER'S MANUAL

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⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes errors do happen and we apologize for them.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, immediately call our technical support for updates or clarification.

For your convenience, we always keep current Grizzly manuals and most updates available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these documents as soon as they are complete. Visit our site often to check for the latest updates!

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Functional Overview

This jointer/planer can flatten the face or edge of rough and warped stock, and reduce the thickness of workpieces.

This jointer/planer shares a single cutterhead, which features two steel knives that remove the bottom face of the workpiece in jointer mode or the top surface of the workpiece in planer mode.

The key features of the jointer are the outfeed and infeed tables and fence, and the main features of the planer are the planing table and the powered feed rollers.

To square up a piece of rough stock, the infeed table is lowered a desired amount. The stock is placed firmly on the jointer infeed table and against the fence. While using the fence as a guide, the workpiece is moved over the cutterhead, where the knives make numerous shallow cuts that “shave” off the surface of the workpiece. The workpiece is received by the outfeed table, which along with the fence, continue to guide the workpiece across a flat plane until it completely passes the cutterhead. This process is repeated a number of times to yield the desired cut.

After the machine is converted to planer mode, the operator adjusts the table height according to the stock thickness and the desired depth of cut. The face of the previously squared-up stock is placed on the table, the workpiece is pushed into the machine, where the infeed roller grabs it and draws it into the cutterhead knives. The powered outfeed roller pulls the workpiece out of the cutterhead and delivers it to the outfeed table. This process is repeated until the board is smooth on one side. The board can be flipped over again and planed on the other side until it is smooth, or it can be edge joined after the machine is converted back to a jointer.

Identification

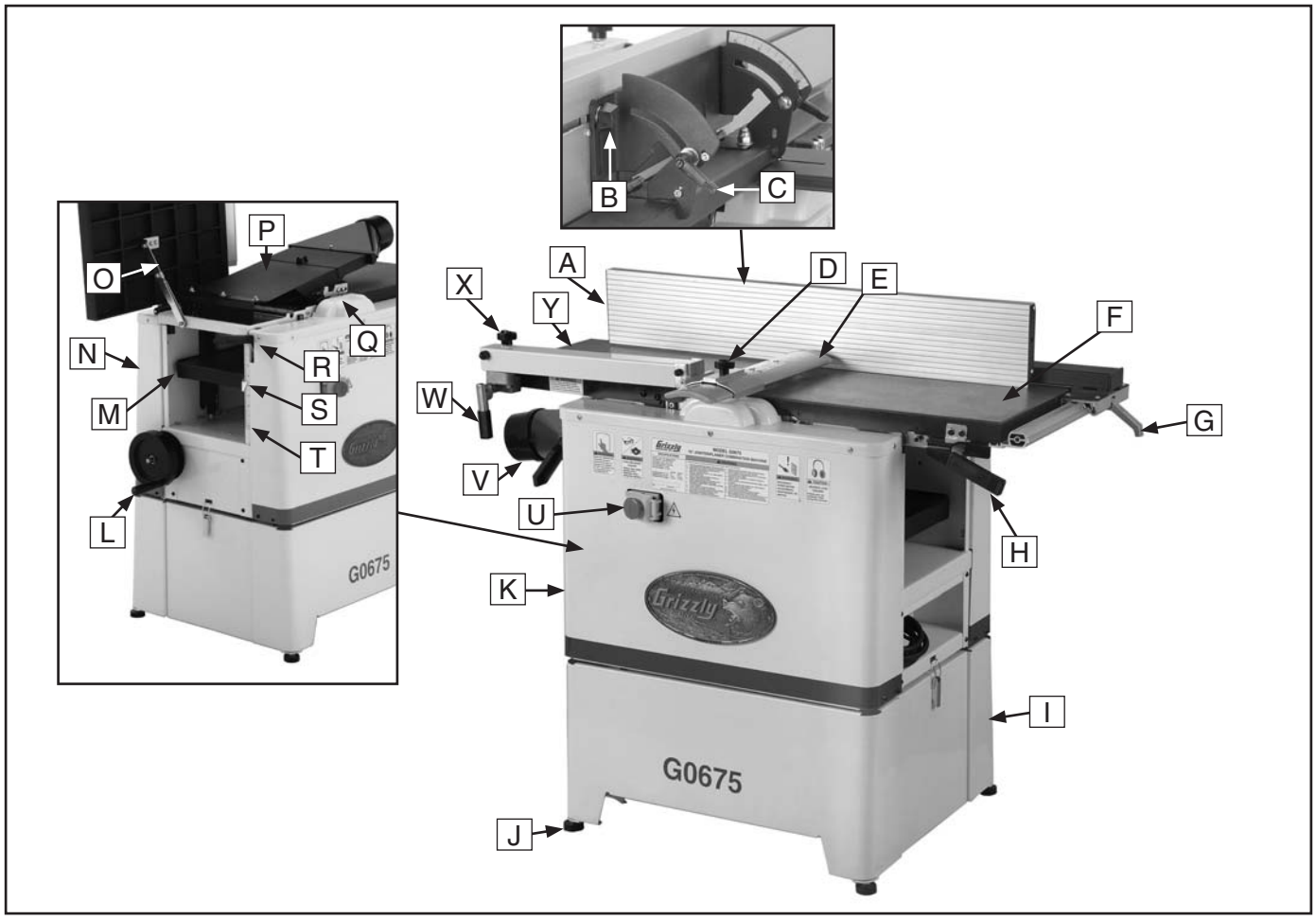


Figure 1. G0675 identification.

A. Fence
B. Fence Height Lock Knob
C. Fence Tilt Lock
D. Blade Guard Lock Knob
E. Blade Guard
F. Infeed Table
G. Fence Lock Lever
H. Infeed Table Adjustment Lever
I. Base
J. Foot
K. Front Access Panel
L. Planer Table Height Handwheel
M. Planer Table
N. Rear Access Panel
O. Outfeed Table Lock Arm
P. Dust Chute Assembly (Planer Operations)
Q. Dust Chute Lock
R. Outfeed Table Lock
S. Planer Table Height Indicator
T. Planer Table Height Scale
U. On/Off Switch
V. 4" Dust Port (Jointer Operations)
W. Blade Guard Arm Lock Lever
X. Blade Guard Arm Adjustment Knob
Y. Outfeed Table

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0675
JOINTER/PLANER COMBINATION MACHINE

Product Dimensions:

Weight	317 lbs.
Length/Width/Height	46" x 27" x 38"
Foot Print (Length/Width)	26" x 22"

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	392 lbs.
Length/Width/Height	43¾" x 24" x 28¾"

Electrical:

Switch	On/Off Buttons
Switch Voltage	220V
Recommended Cord Gauge	14 Gauge
Recommended Breaker Size	15A
Plug	NEMA 6-15

Motors:

Main

Type	TEFC Capacitor Start Induction
Horsepower	2.5 HP
Voltage	220V
Phase	Single
Amps	9.9A
Speed	3400 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	Poly V-Belt
Bearings	Shielded and Lubricated

Main Specifications:

Fence Information

Fence Length	35 7/16"
Fence Height	5 7/8"
Fence Stops	45 and 90 deg.

Cutting Capacities (Jointer)

Bevel Jointing	0-45 deg.
Maximum Width of Cut	10¼"
Maximum Depth of Cut	⅛"
Number of Cuts Per Minute	13000

Cutting Capacities (Planer)

Maximum Width of Cut	9 27/32"
Maximum Depth of Cut Planing Full Width	3/16"
Number of Cuts Per Minute	13000
Number of Feed Speeds	1

Feed Speed ..... 16 FPM
Minimum Stock Length ..... 11 13/16"
Maximum Stock Thickness ..... 8 1/4"

Knife Information (Jointer)

Number of Knives 2
Knife Type ..... HSS
Knife Length. ..... 10 1/4"
Knife Width. ..... 11/16"
Knife Thickness. ..... 1/8"
Knife Adjustment. ..... Jack Screws

Cutterhead Information

Cutterhead Type ..... 2 HSS Knives
Cutterhead Diameter ..... 2 9/32"
Cutterhead Speed ..... 6500 RPM

Table Information (Jointer)

Table Length ..... 40 15/16"
Table Width ..... 12 13/32"
Floor To Table Height ..... 33 55/64"

Table Information (Planer)

Table Length ..... 23 15/64"
Table Width ..... 9 3/4"
Table Thickness ..... 1 1/2"
Floor To Table Height ..... 23"-30"

Construction

Body Assembly Construction ..... Sheet Metal
Cutterhead Assembly Construction ..... Steel
Infeed Roller Construction ..... Steel w/Vulcanized Rubber Coating
Outfeed Roller Construction ..... Steel w/Vulcanized Rubber Coating
Jointer Table Construction ..... Cast Iron
Paint. ..... Powder Coated

Other Infomation

Dust Port Size ..... 4"
Number of Dust Ports 1
Measurement Scale (Jointer) ..... mm
Measurement Scale (Planer) ..... mm

Other Specifications:

Country Of Origin ..... China
Warranty ..... 1 Year
Serial Number Location ..... ID Label on Front of the Stand

Features:

Quick release fence
Flip up outfeed table and change lever simplify jointer-planer conversion
Vulcanized rubber feed rollers (planer mode)
Heavy duty cast iron infeed and outfeed tables, easily and accurately adjustable
Cutterhead guard adjustable for workpiece height
Dust hood position adjustable for jointer or planer conversion

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

⚠WARNING

Safety Instructions for Machinery

1. **READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

⚠WARNING
Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.

8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.

9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power ***OFF*** and allow all moving parts to come to a complete stop before leaving machine unattended.

11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.

13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.

14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY**. Make sure switch is in OFF position before reconnecting.

15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**

17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery ***ON***.

18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.

19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.

20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.

21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

22. **DO NOT OVERREACH.** Maintain stability and balance at all times.

23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY**.

25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.

⚠WARNING
Additional Safety Instructions for Jointers

1. **JOINTER KICKBACK.** "Kickback" is when the workpiece is thrown off the jointer table by the force of the cutterhead. Always use push blocks and safety glasses to reduce the likelihood of injury from “kickback.” If you do not understand what kickback is, or how it occurs, **DO NOT** operate this machine.

2. **CUTTERHEAD ALIGNMENT.** Keep the top edge of the outfeed table aligned with the cutterhead knife at top dead center (TDC) to avoid kickback and personal injuries.

3. **PUSH BLOCKS.** Always use push blocks whenever surface planing. Never pass your hands directly over the cutterhead without a push block.

4. **WORKPIECE SUPPORT.** Supporting the workpiece adequately at all times while cutting is crucial for making safe cuts and avoiding injury. Never attempt to make a cut with an unstable workpiece.

5. **KICKBACK ZONE.** The "kickback zone" is the path directly through the end of the infeed table. Never stand or allow others to stand in this area during operation.

6. **MAXIMUM CUTTING DEPTH.** The maximum cutting depth for one pass is ⅛". Never attempt any single cut deeper than this!

7. **CUTTING LIMITATIONS.** The jointer may kick out a workpiece at the operator or be damaged if pushed beyond these limits.
   - Maximum Depth of Cut ..... ⅛"
   - Maximum Width of Cut ..... 10¼"
   - Minimum Length ..... 12"

8. **JOINTING WITH THE GRAIN**. Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip-out. Always joint with the grain.

9. **KEEPING GUARDS IN PLACE.** All operations must be performed with the cutterhead guard in place.

10. **PROPER CUTTING.** When cutting, always keep the workpiece moving toward the outfeed table until the workpiece has passed completely over the cutterhead. Never back the work toward the infeed table.

11. **USING GOOD STOCK.** Jointing safety begins with your lumber. Inspect your stock carefully before you feed it over the cutterhead. Never joint a board that has loose knots, nails, or staples. If you have any doubts about the stability or structural integrity of your stock, DO NOT joint it!

⚠WARNING

Like all machines there is danger associated with this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

⚠WARNING
Additional Safety Instructions for Planers

1. **KICKBACK.** "Kickback" is when the workpiece is thrown off the planer table by the force of the cutterhead. If you do not understand what kickback is, or how it occurs, **DO NOT** operate this machine.

2. **REACHING INSIDE PLANER.** Never reach inside the planer or remove covers when the planer is connected to power.

3. **INFEED CLEARANCE SAFETY.** The infeed roller is designed to pull material into the cutterhead. Always keep hands, clothing, and long hair away from the infeed roller during operation to prevent serious injury.

4. **BODY POSITION WHILE OPERATING.** The workpiece may kick out during operation. To avoid getting hit, stand to the side of the planer during the entire operation.

5. **PLANING CORRECT MATERIAL.** Only plane natural wood stock with this planer. DO NOT plane MDF, plywood, laminates, or other synthetic products.

6. **GRAIN DIRECTION.** Planing across the grain is hard on the planer and may cause the workpiece to kick out. Always plane in the same direction or at a slight angle with the wood grain.

7. **LOOKING INSIDE PLANER.** Wood chips fly around inside the planer at a high rate of speed. DO NOT look inside the planer or remove guards/covers when the planer is connected to power or during operation.

8. **CUTTING LIMITATIONS.** The planer may kick out a workpiece at the operator or be damaged if pushed beyond these limits.
   - Maximum Depth of Cut ..... 3/16"
   - Maximum Width of Cut ..... 9 27/32"
   - Minimum Board Length..... 12"
   - Maximum Board Thickness ..... 8 1/4"

9. **CLEAN STOCK.** Only plane clean stock. Planing stock with nails, staples, or imbedded stone will damage your knives and may cause a fire hazard if the dust collector captures sparks or hot particles that have contacted the knives. Always thoroughly inspect and prepare stock to avoid these hazards.

10. **REMOVING JAMMED WORKPIECES.** To avoid serious injury, always stop the planer and disconnect power before removing jammed workpieces.

11. **DULL/DAMAGED KNIVES.** The planer may kick out a workpiece at the operator or give poor finish results if it is operated with dull or damaged knives.

12. **UNPLUGGING DURING ADJUSTMENTS.** When connected to power, the planer can be accidentally turned ***ON***. Always disconnect power when servicing or adjusting the components of the planer.

13. **WORKPIECE CLEARANCE.** Always verify workpiece has enough room to exit the planer before starting.

SECTION 2: CIRCUIT REQUIREMENTS

220V Operation

⚠WARNING

Serious personal injury could occur if you connect the machine to power before completing the setup process. DO NOT connect the machine to the power until instructed later in this manual.

⚠WARNING

Electrocution or fire could result if machine is not grounded and installed in compliance with electrical codes. Compliance MUST be verified by a qualified electrician!

Full Load Amperage Draw

This machine draws the following amps under maximum load:

Amp Draw.....9.9 Amps

Power Supply Circuit Requirements

The power supply circuit for your machine MUST be grounded and rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

Minimum Circuit Size..... 15 Amps

Power Connection Device

The Model G0675 comes with a 6-15 plug, similar to **Figure 2** to connect the machine to power.

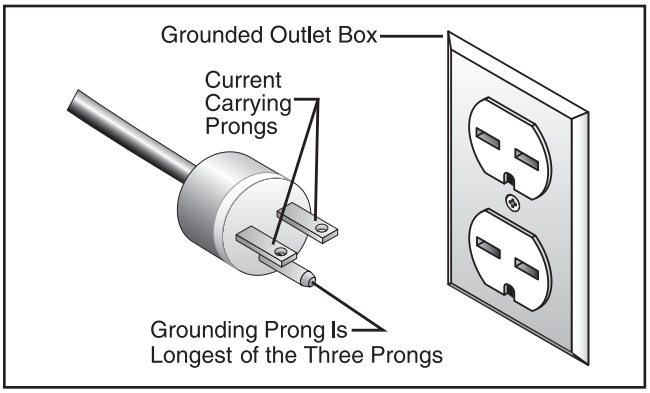


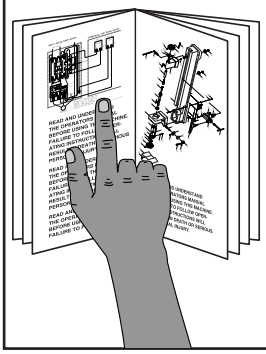
Figure 2. NEMA 6-15 plug and receptacle.

Extension Cords

Using extension cords may reduce the life of the motor. Instead, place the machine near a power source. If you must use an extension cord:

- Use at least a 14 gauge cord that does not exceed 50 feet in length!
- The extension cord must also have a ground wire and plug pin.
- A qualified electrician MUST size cords over 50 feet long to prevent motor damage.

SECTION 3: SETUP



⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire setup process!

⚠WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Safety Glasses for Each Person	1
• Power Lifting Equipment	1
• Dust Collection System	1
• 4" Dust Hose (length as needed)	1
• 4" Hose Clamp	1
• Shop Rags and Cleaning Solvent	Varies
• Wrench 16mm	1
• Precision Level	1
• Lifting Help/Assistant	1

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.

Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Box 1: (Figure 3)		**Qty**
A.	Jointer/Planer Unit (not shown)	1
B.	Fence Assembly	1
C.	Blade Guard Arm Assembly	1
D.	Blade Guard	1
E.	Blade Adjustment Gauge	1
F.	Dust Port	1
G.	Hex Wrench 5mm	1
H.	Wrench 8/10mm	1

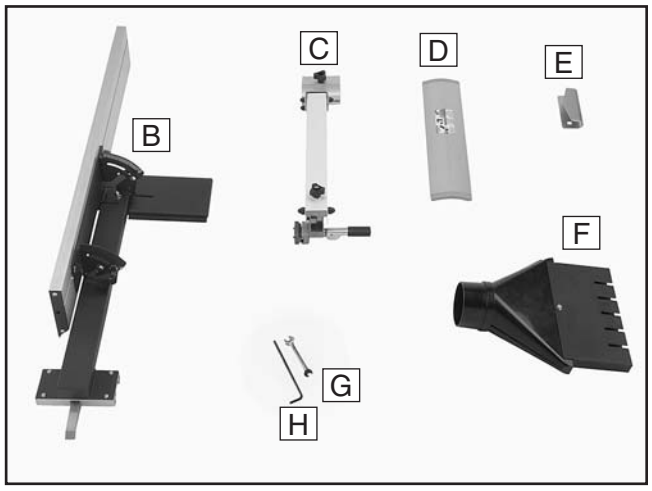


Figure 3. G0675 inventory.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

⚠WARNING

SUFFOCATION HAZARD!
Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser, such as shown in **Figure 4**. For thorough cleaning, some parts must be removed. **For optimum performance, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.

⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

G2544—Solvent Cleaner & Degreaser
H9692—Orange Power Degreaser
Great products for removing shipping grease.

Figure 4. Cleaner/degreasers available from Grizzly.

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 5** for the minimum working clearances.

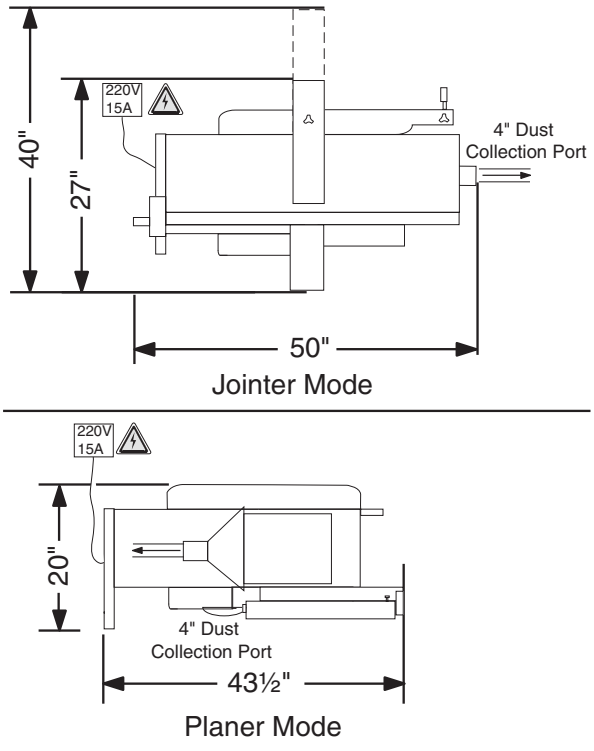
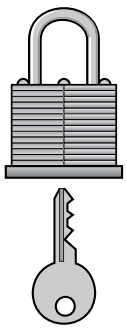


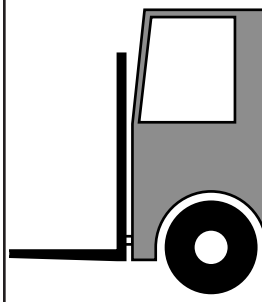
Figure 5. Minimum working clearances.



⚠CAUTION

Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.

Moving & Placing Base Unit



⚠WARNING

The Model G0675 is a heavy machine. Serious personal injury may occur if safe moving methods are not used. To be safe, get assistance and use power equipment to move the shipping crate and remove the machine from the crate.

Use a forklift to lift the jointer/planer just enough to clear the shipping pallet and floor obstacles, then move it to a suitable location, as shown in **Figure 6**.

Figure 6. Lifting model G0675 with a forklift.

If you are unsure how to lift this machine, consult a qualified professional.

Place a level on the table and level the machine front-to-back and side-to-side by adjusting the height of the feet. Raise or lower each rubber foot by turning the hex nut above each foot with a 16mm wrench, then tighten the top locking nut.

If you have trouble adjusting the feet, unlatch the top from the base and, with the help of an assistant, set it aside. Adjust the feet, level the base, secure the hex nuts, then reinstall the top with the assistant's help.

Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included.

To mount the base to the floor:

1. Unlatch the machine top from the base at both ends (**Figure 7**).

Figure 7. Location of latches.

2. With the help of an assistant set the machine top aside.

3. Remove the rubber feet and install 10mm or ⅜" bolts through the mounting holes (**Figure 8**) .

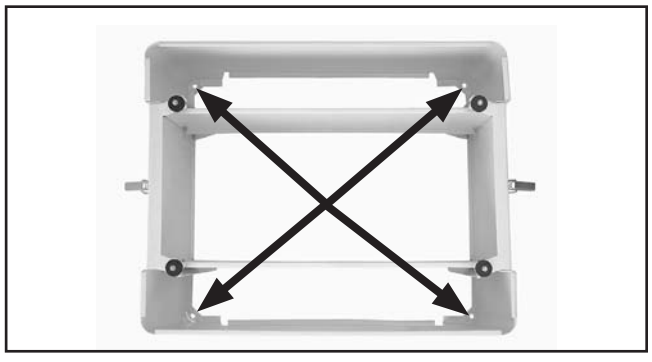


Figure 8. Base mounting holes.

4. Level the base with a precision level and shims, as needed.

5. Set the machine top back on the base and secure the latches.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 9**) and anchor studs are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

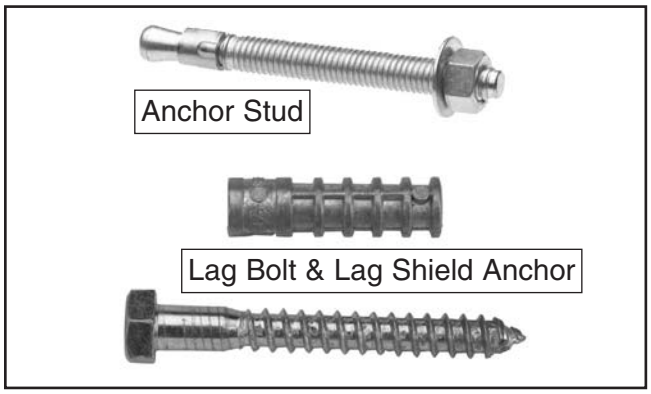


Figure 9. Typical fasteners for mounting to concrete floors.

Assembly

This section covers how to setup your machine for jointing operations. Once you have completed the assembly and **Test Run** (**Page 18**), you can convert the machine for planer operation (refer to **Page 22**).

To assemble the machine:

1. Pull up on the fence lock lever, then place the fence assembly onto the table fence rail, as shown in **Figure 10**.

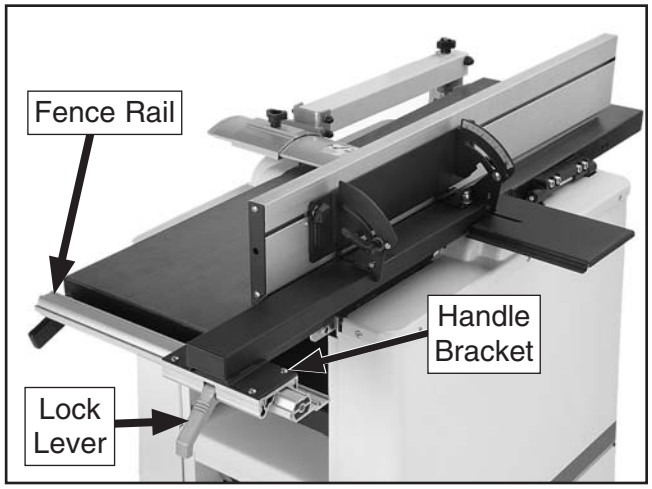


Figure 10. Fence installed.

2. Engage the blade guard lever, align the cap screws on the arm with the mounting holes on the outfeed table, then tighten the screws (see detail in **Figure 11**).

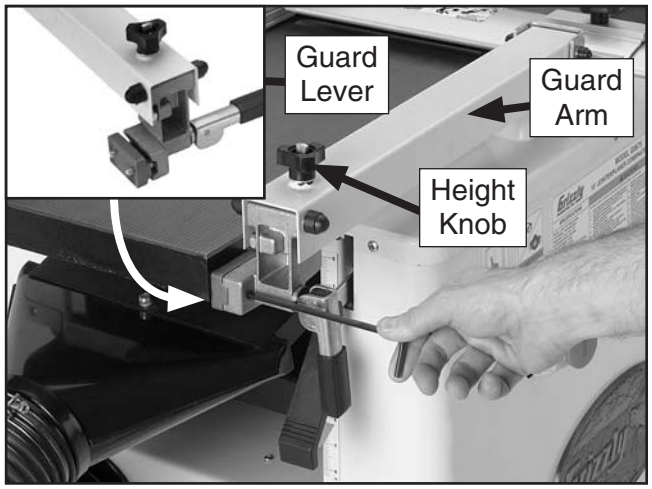


Figure 11. Blade guard arm installed.

Tip: *Try tightening one cap screw several turns, then repeat with other until both are tight.*

3. Loosen the guard lock knob, slide the blade guard into the bracket, then tighten the lock knob (see **Figure 12**).

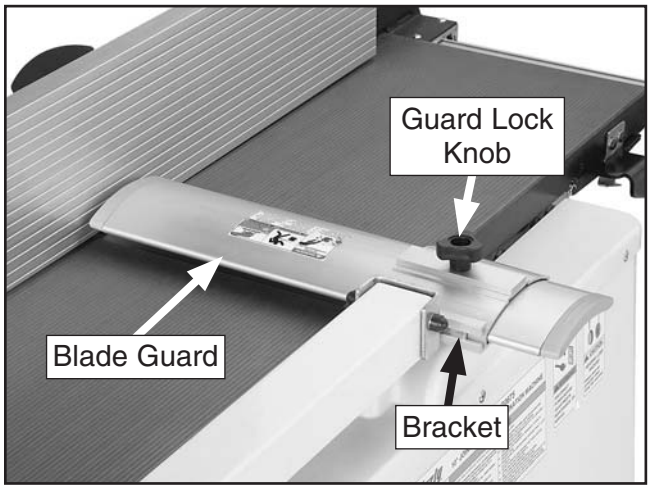


Figure 12. Blade guard installed.

To raise the blade guard, turn the height adjustment knob counterclockwise (**Figure 11**); to lower the blade guard, turn the knob clockwise.

4. Loosen the thumb screw on the dust hood assembly, insert the dust port into the dust hood assembly, then tighten the thumb screw (see **Figure 13**). Make sure the fingers on the dust hood slide all the way into the grooves on the port.

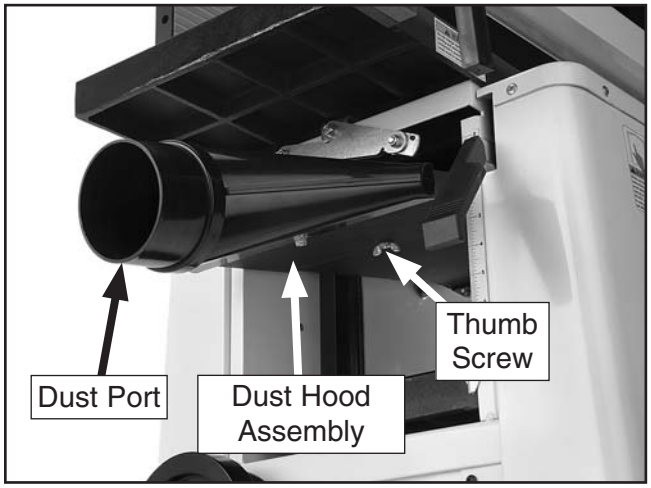


Figure 13. Installing dust port.

Dust Collection

⚠CAUTION

DO NOT operate the Model G0675 without an adequate dust collection system. This machine creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in long-term respiratory illness.

Recommended CFM at Dust Port: 400 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit the 4" dust hose over the dust port when it is correctly positioned for jointer operation (**Figure 14**) or planer operation (**Figure 15**), and secure in place with a hose clamp.

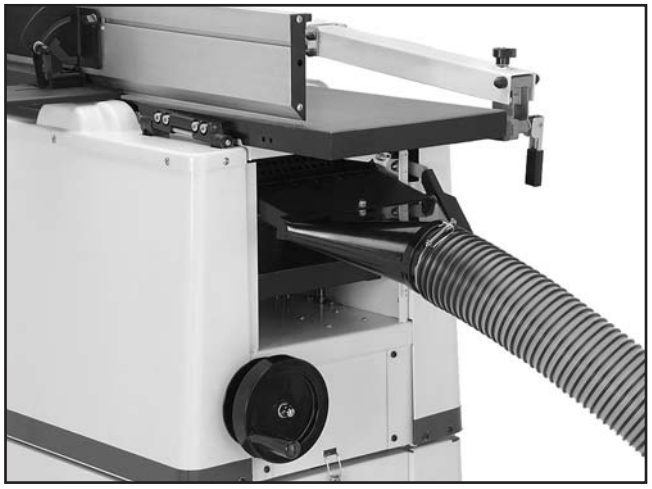


Figure 14. Dust hose attached to dust port setup for jointer operations.

Figure 15. Dust hose attached to dust port setup for planer operations.

Refer to the instructions on **Page 22** (**Planer Operations Setup**) for setting up the dust chute for planer operations.

2. Tug the hose to make sure it does not come off.

Note: *A tight fit is necessary for proper performance.*

Setting Outfeed Table Height

The outfeed table height MUST be level with the knives when they are at top-dead-center. If the outfeed table is set too low, the workpiece will be tapered. If the outfeed table is set too high, the workpiece will hit the edge of the outfeed table during operation, increasing the chance of kickback.

To set the outfeed table height:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Move the blade guard out of the way or remove it.

3. Secure the outfeed table with the outfeed table lock.

4. Remove the front access panel (see **Replacing Flat Drive Belt, Steps 3-4** on **Page 33**) to access the cutterhead pulley.

5. Place the knife setting gauge on the front of the outfeed table so the gauge extends over the cutterhead and the outward mark is at the edge of the outfeed table (**Figure 16**).

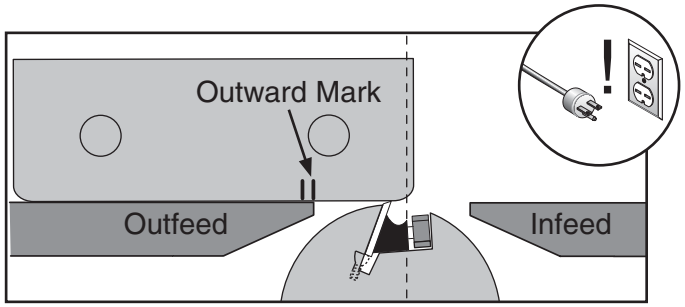


Figure 16. Knife gauge positioned over cutterhead knife.

6. Rotate the cutterhead pulley until one of the knives is at top dead center (TDC), as shown in **Figure 17**.

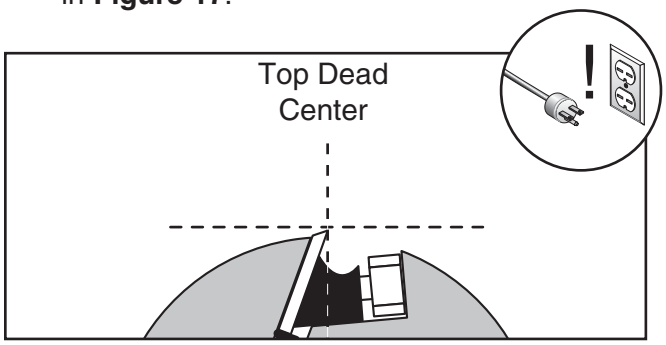


Figure 17. Cutterhead knife at top-dead-center.

7. When the outfeed table is correctly set, the knife will just touch the gauge when the knife is at its highest point of rotation (**Figure 18**). When the cutterhead pulley is rotated, the gauge should move ⅛" toward the infeed table and the inward mark should be directly over the edge of the outfeed table (**Figure 18**).

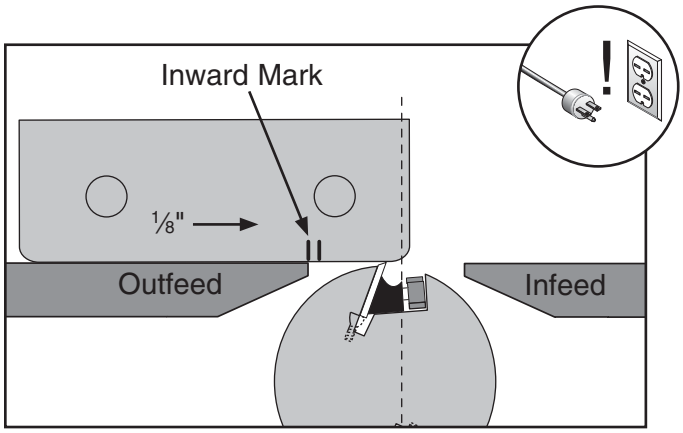


Figure 18. Knife gauge positioned over cutterhead knife.

—If your outfeed table is correctly set, no adjustments are necessary.

—If the knife lifts the gauge off the table or the table is below the gauge, continue to **Checking Outfeed Table Parallelism** on **Page 39** in the SERVICE section.

8. Reinstall the front access panel and blade guard.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the cutterhead safety switch works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 37**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and you have performed the assembly instructions.

2. Make sure all tools and objects used during setup are cleared away from the machine.

3. Push the outfeed table lock lever down.

4. Connect the machine to the power source.

5. Open the switch cover and press the green ON button to turn the machine ***ON***.

6. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

   —Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

7. Turn the machine ***OFF***.

8. Move the fence all the way back and completely cover the cutterhead with the blade guard.

9. Disengage the outfeed table lock lever, lift the outfeed table up about an inch or until you hear a "click" then turn the machine ***ON***.

   —If the cutterhead does not rotate, the cutterhead safety switch is working correctly. Continue to **Step 10**.

   —If the cutterhead rotates, immediately stop the machine and DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE! The safety switch is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

10. Set the machine up for planer operations. Refer to **Planer Operation Setup, Steps 1-5** on **Page 22,** for detailed instructions.

11. Swing the dust chute assembly clockwise over the cutterhead and rest the catch lever on the infeed table, as shown in **Figure 19**.

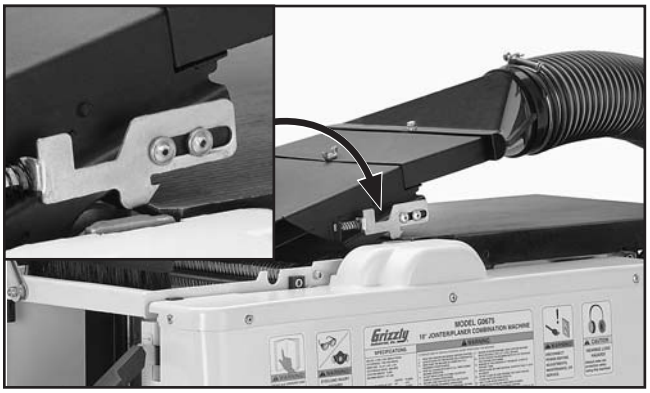


Figure 19. Dust chute catch disengaged.

12. Turn the machine ***ON***.

    —If the cutterhead does not rotate, the cutterhead safety switch is working correctly. The test run is complete.

    —If the cutterhead rotates, immediately stop the machine and DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE! The safety switch is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

13. To finish setting up the machine for planer operation, push the dust chute down until you hear a "click," indicating the dust chute is locked, then connect the dust hose.

14. To convert the machine to a jointer, follow the **Jointer Operation Setup** on **Page 23**.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine.

However, because of the many variables involved with shipping and storage, some of these adjustments may need to be repeated to ensure optimum cutting results. Keep this in mind as you start to use your new jointer/planer.

Step-by-step instructions for these adjustments can be found in **SECTION 7: SERVICE ADJUSTMENTS.**

Factory adjustments that should be verified:

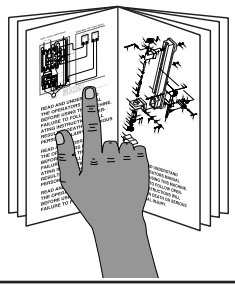
1. Cutterhead Knife Height (**Page 42**)
2. Fence Stop Accuracy (**Page 44**)
3. Feed Roller Spring Tension (**Page 46**)
4. Jointer-Table Parallelism (**Page 39**)

Belt Break-In

The final step in the setup process must be done after approximately three hours of operation. During this first three hours, the belts will stretch and seat into the pulley grooves. After this, you must re-tension the belts to avoid slippage and burn out. Refer to **Page 32** when you are ready to perform this important adjustment.

Note: *Pulleys and belts can get hot. This is a normal condition. Allow them to cool before making adjustments.*

SECTION 4: OPERATIONS

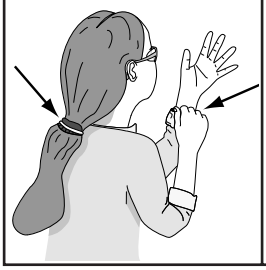


WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



WARNING

Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Jointer Controls

This section covers the controls used during routine jointer operations. To use the machine as a planer, you must perform a conversion (see **Jointer-Planer Conversion** on **Page 22**).

ON/OFF Button (Figure 20): Starts or stops motor when pushed in.

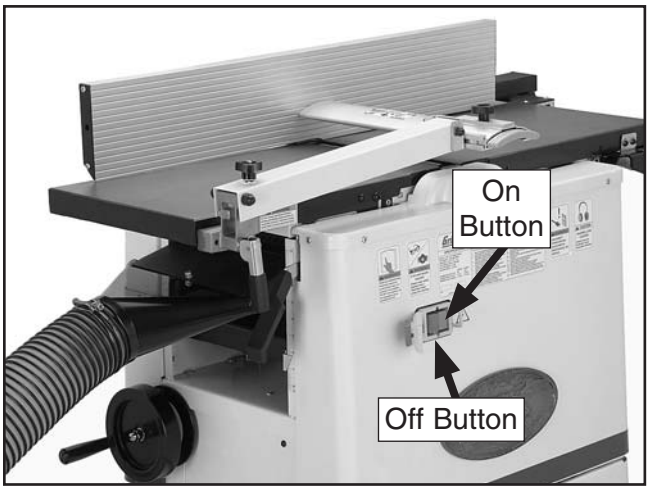


Figure 20. ON/OFF button locations.

Table Movement: Raise or lower the infeed table adjustment lever (**Figure 21**) to control how much stock is removed by the cutterhead.

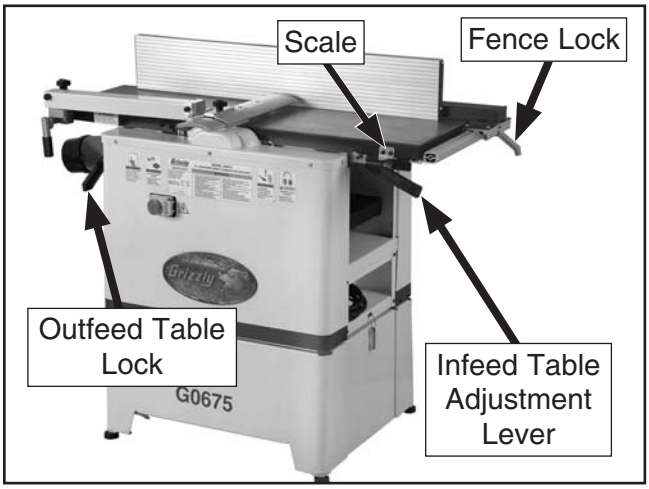


Figure 21. Fence and table height controls.

To unlock the outfeed table, raise the outfeed table lock lever. To lock the outfeed table, lower the outfeed table, then engage the lock lever.

Fence Movement: The fence lock keeps the fence in position (**Figure 21**). To move the fence, loosen the fence lock, slide the fence to the desired position, then secure the lock.

Fence Tilting: The tilt locks (**Figure 22**) secure the fence at any position in the available range. Fence stops set the fence at 90° or 45° outward. The tilt locks must be tightened before cutting. See **Page 44** for more detail on setting the fence stops.

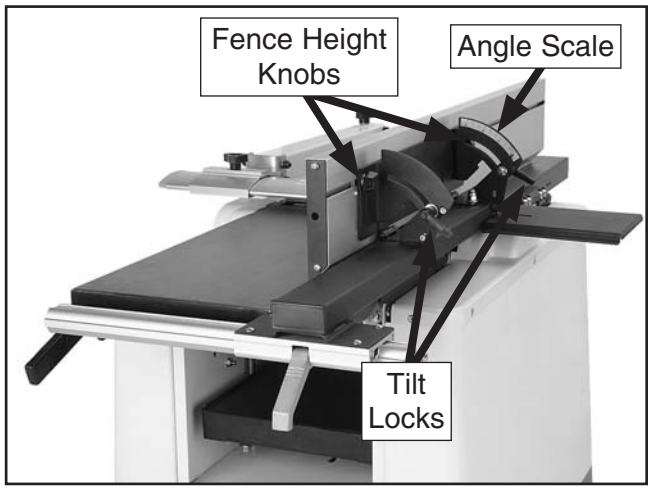


Figure 22. Fence tilt controls.

To move the fence to 45° outward, loosen the tilt locks and fence height knobs, move the blade guard away from the fence several inches, and move the fence bevel flush against the table (see **Figure 23**). Verify the angle with a 45° square, then tighten the height knobs and tilt locks.

To return the fence to the 90° position, loosen the tilt locks and height knobs, raise the fence to 90°. Check the fence angle with a 90° square, making sure the fence and table are flush, then tighten the height knobs and tilt locks.

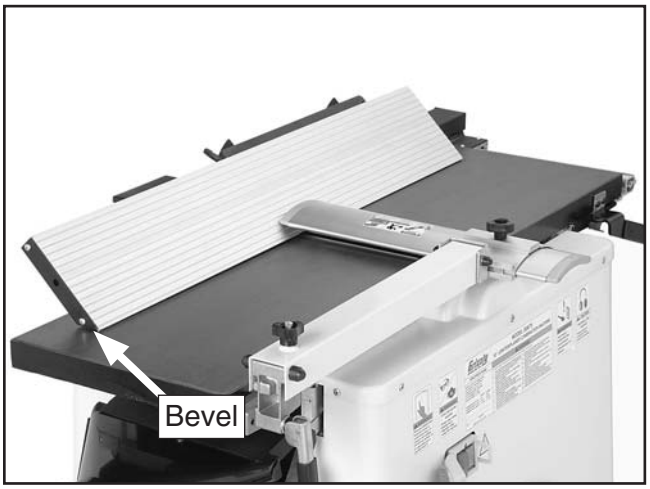


Figure 23. Fence bevel flush with table at 45°.

Blade Guard: To position the blade guard over the cutterhead (**Figure 24**), loosen the lock knob, reposition the guard, then tighten the lock knob. Place the guard as close as possible to the cutterhead during operations to reduce the risk of serious injury from cutterhead contact—while also allowing adequate clearance for workpieces.

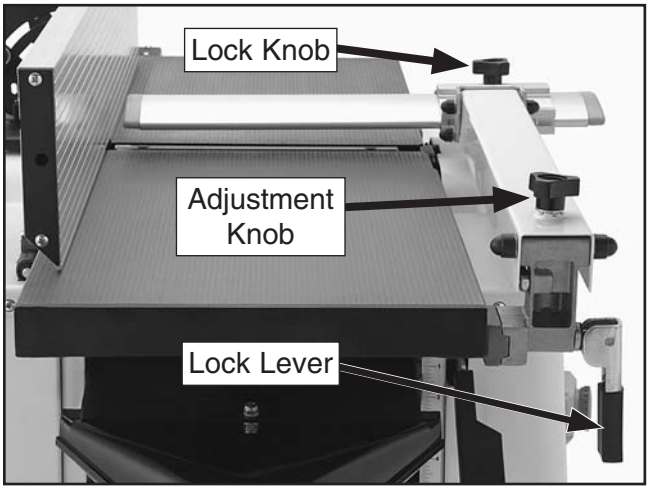


Figure 24. Blade guard controls.

Blade Guard Arm: To adjust the blade guard height, turn the adjustment knob (see **Figure 24**) clockwise to lower and counterclockwise to raise the blade guard. To move the bracket and blade guard out of the way, disengage the lock lever, then rotate the bracket assembly away from the outfeed table.

Basic Planer Controls

This section covers the controls used during routine planer operations.

See **Page 20** for a description of the ON/OFF switch.

Table Height Handwheel: To raise or lower the planer table, rotate the table height handwheel (**Figure 25**).

Table Height Scale: Read the depth-of-cut from the inch scale.

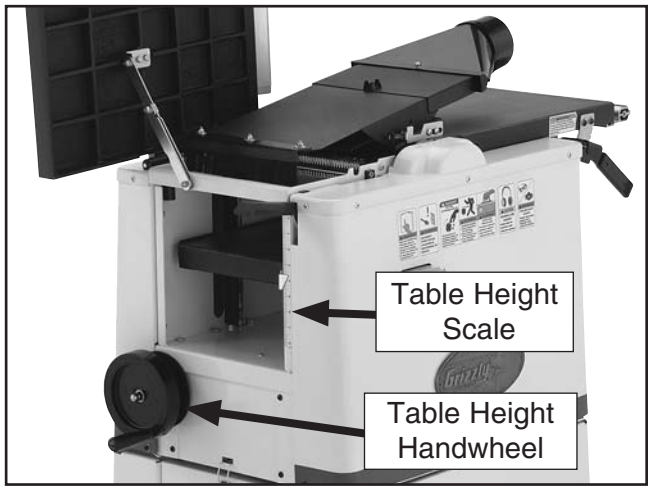


Figure 25. Planer table control locations.

Jointer-Planer Conversion

The Model G0675 is ready for jointer operations after it is setup. To use the machine as a planer, you must perform a conversion.

Planer Operation Setup

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Loosen the fence lock lever, then remove the fence.

3. Engage the blade guard lock knob and blade guard arm lock lever (see **Figure 24** on **Page 21**).

4. Disengage the outfeed table lock lever, and raise the table up all the way so the pin seats into the groove on the lock arm (**Figure 26**).

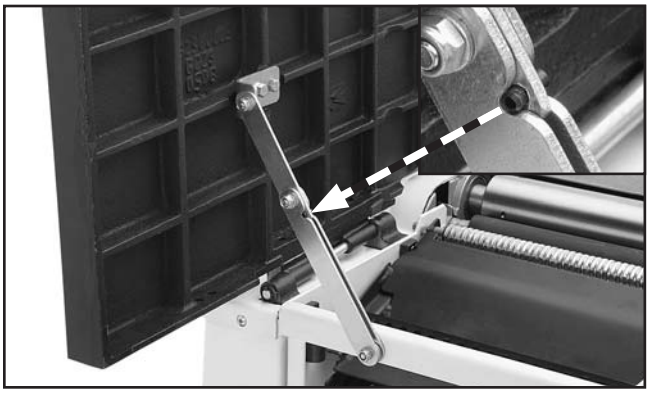


Figure 26. Outfeed table lock arm.

⚠CAUTION

Serious personal injury could occur if you place your fingers between the table and base or between pivot points. Your hands could be pinched or crushed!

5. Remove the dust hose from the jointer dust port, then remove the dust port.

6. Use the table height handwheel to lower the planer table to approximately the 6" mark.

7. Swing the dust chute assembly clockwise over the cutterhead, then push it down onto the infeed table until you hear a "click"—this indicates that the lock lever (**Figure 27**) has secured the infeed table. The lever must engage the infeed table for the planer to operate.

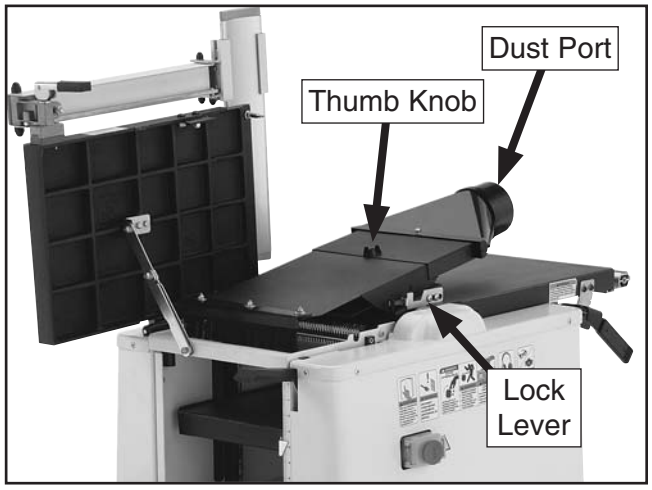


Figure 27. Dust chute secured.

NOTICE

The dust chute must be secured during planer operations or the machine will not operate. If the machine DOES operate when the dust chute lock is disengaged, immediately DISCONNECT THE JOINTER/PLANER FROM POWER and call Technical Support.

8. Install the dust port onto the dust chute with the thumb knob, as shown in **Figure 27,** then install the dust hose with a hose clamp.

Jointer Operation Setup

1. Reverse **Steps 2–8** in the previous subsection. You must push the catch lever back to release the dust port.

2. While holding the outfeed table up, push the lock arm pin out to fold the lock arm in and lower the outfeed table most of the way (**Figure 26**). When the table is close to the frame, raise the outfeed table lock lever, lower the table the rest of the way, then push the lever down to secure the outfeed table.

3. Re-install the fence.

Stock Inspection and Requirements

Here are some rules to follow when choosing stock for the jointer/planer:

- **DO NOT joint or surface plane stock that contains knots.** Injury to the operator or damage to the workpiece can occur if the knots become dislodged during the cutting operation.

- **DO NOT joint or surface plane against the grain direction.** Cutting against the grain increases the likelihood of stock kickback, as well as tear-out on the workpiece.

- **Jointing and surface planing with the grain produces a better finish and is safer for the operator.** Cutting with the grain is described as feeding the stock so the grain points down and toward you on the jointer (**Figure 28**) or away from you on the planer (**Figure 29**), as viewed from the edge.

  Note: *If the grain changes direction along the edge of the board, decrease the cutting depth and make additional passes.*

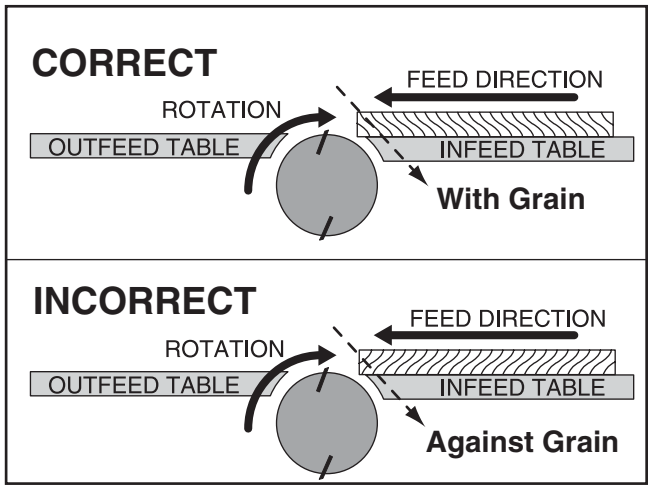


Figure 28. Correct and incorrect grain alignment to cutterhead (jointer).

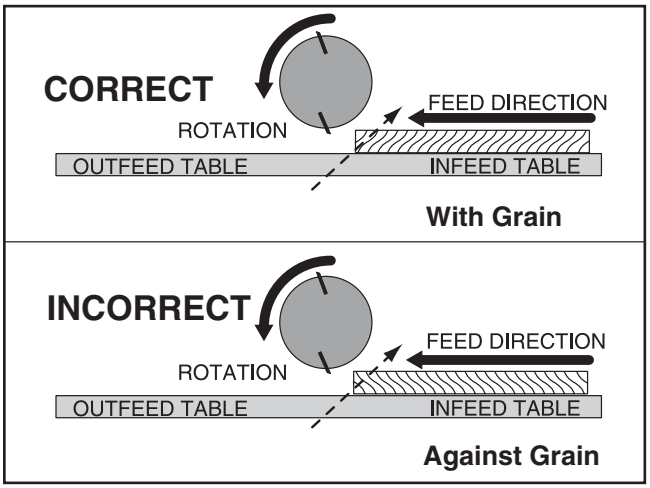


Figure 29. Correct and incorrect grain alignment to cutterhead (planer).

- **Remove foreign objects from the stock.** Make sure that any stock you process with the jointer/planer is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects, which if they hit the knives and are drawn into the dust collector, may cause a fire hazard. The particles may also damage the knives. Wood stacked on a concrete floor can have small pieces of stone or concrete pressed into the surface.

- **Only process natural wood fiber through your jointer/planer.** Never joint MDF, particle board, plywood, laminates or other synthetically made materials.

- **Make sure all stock is sufficiently dried before jointing or planing.** Wood with a moisture content over 20% will cause unnecessary wear on the knives and poor cutting results. Excess moisture can also hasten rust and corrosion.

- **Scrape all glue off of boards before planing.**

- **Keep your work area clear.**

Jointer Specific Rules:

- **Make sure your workpiece exceeds the minimum dimension requirements (Figures 30 & 31) before edge jointing or surface planing, or it may break or kick back during the operation!**

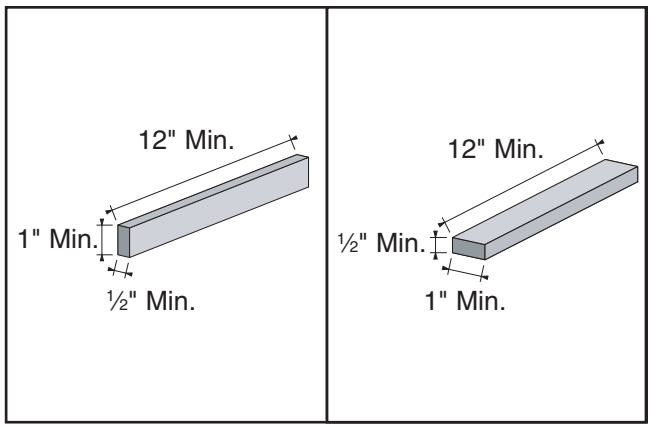


Figure 30. Minimum dimensions for edge jointing and surface planing (jointer).

Thickness Planer Specific Rules:

- Use the full width of the planer. Alternate between the left, the right, and the middle when feeding narrow lumber into the planer. Your knives will remain sharp much longer.

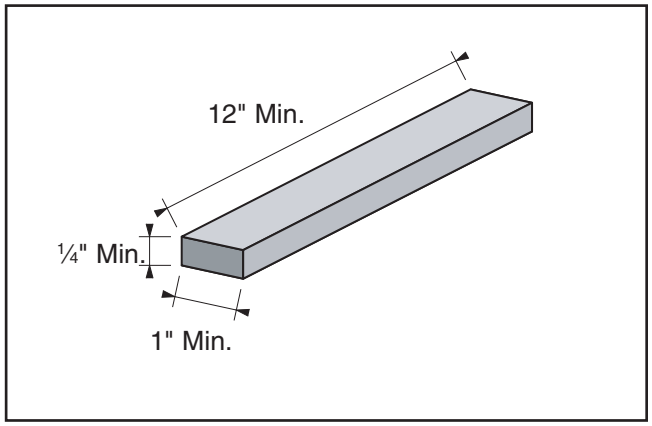
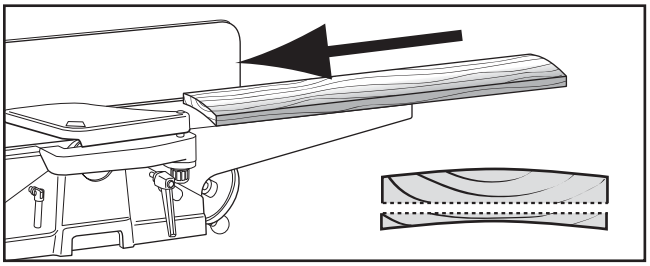


Figure 31. Minimum dimensions for surface planing (thickness planer).

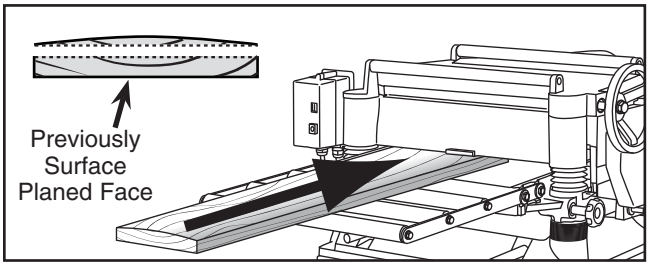
Squaring Stock

Squaring stock involves four steps performed in the order below:

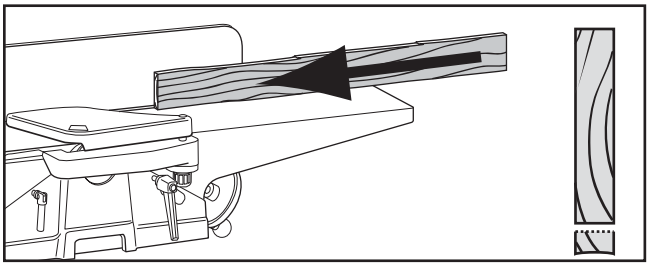
1. **Surface Plane on the Jointer**—The concave face of the workpiece is surface planed flat with a jointer.



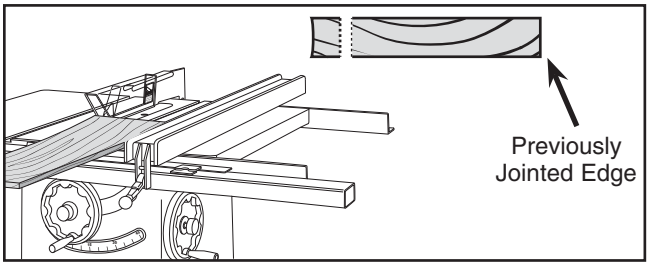
2. **Surface Plane on the Thickness Planer**—The opposite face of the workpiece is surface planed flat with a thickness planer.



3. **Edge Joint on the Jointer**—The concave edge of the workpiece is jointed flat with a jointer.



4. **Rip Cut on a Table Saw**—The jointed edge of the workpiece is placed against a table saw fence and the opposite edge cut off.



Surface Planing

The purpose of surface planing on the jointer is to make one flat face on a piece of stock (see **Figures 32–34**) to prepare it for thickness planing on the planer.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described. This procedure will better prepare you for the actual operation.

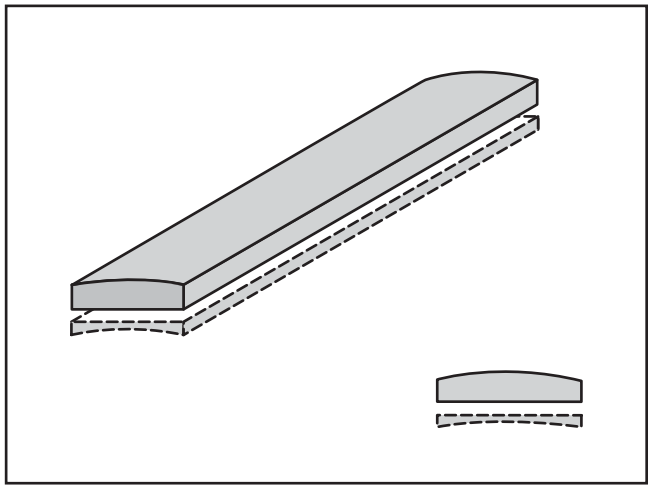


Figure 32. Illustration of surface planing results.

To surface plane on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 24**.

3. Set the cutting depth for your operation. (We suggest 1/32" for surface planing, using a more shallow depth for hard wood species or for wide stock.)

4. Make sure your fence is set to 90˚.

5. Adjust the blade guard for the workpiece thickness.

   —If the workpiece is less than or equal to 3" thick, adjust the guard so it touches the fence and is just above the workpiece—allowing the workpiece to move freely (see **Figure 33**). Tighten the blade guard lock knob.

Figure 33. Surface planing board less than 3" thick.

   —If the workpiece is greater than 3" thick, adjust the blade guard 3/8" to 1/2" away from the workpiece (see **Figure 34**), lower the guard to its lowest position (about 3/4" over the cutterhead) then tighten the blade guard lock knob.

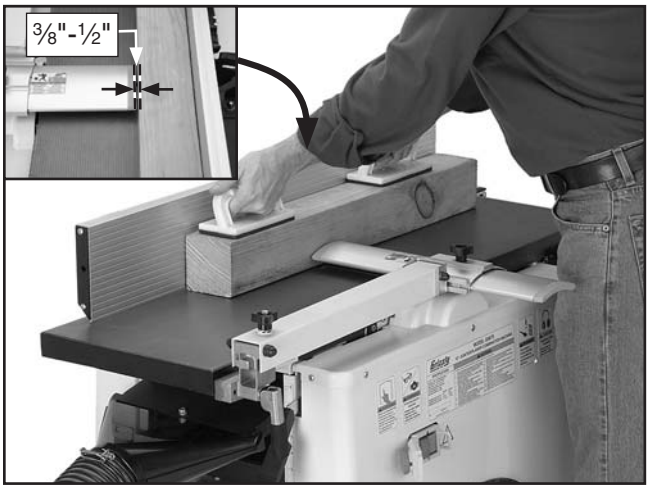


Figure 34. Surface planing stock greater than 3" thick.

⚠WARNING

Failure to use push blocks when surface planing may result in cutterhead contact, which will cause serious personal injury. Always use push blocks to protect your hands when surface planing on the jointer.

6. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.

7. Start the jointer.

8. With a push block in each hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.

Note: *If your leading hand (with push block) gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

9. Repeat **Step 8** until the entire surface is flat.

Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface (see **Figures 35 & 36**) that is suitable for joinery or finishing. It is also a necessary step when squaring rough or warped stock.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.

Figure 35. Edge jointing operation.

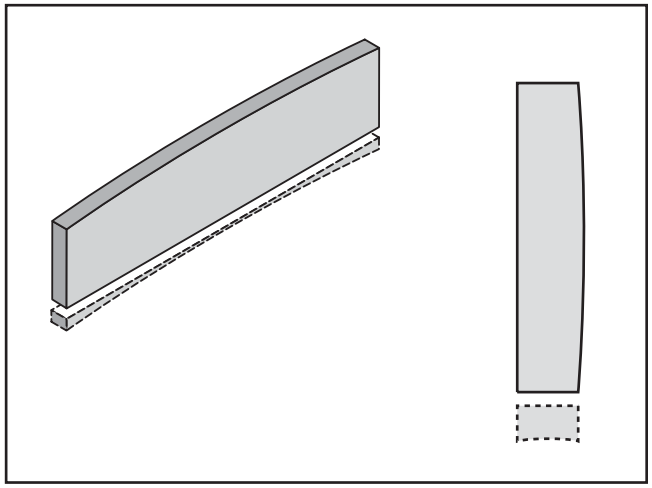


Figure 36. Illustration of edge jointing results.

To edge joint on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 24**.

3. Set the cutting depth for your operation. (We suggest between 1/16" and 1/8" for edge jointing, using a more shallow depth for hard wood species or for wide stock.)

4. Make sure the fence is set to 90°, adjust the blade guard 3/8" to 1/2" away from the workpiece (see **Figure 35**), then tighten the blade guard lock knob.

5. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.

6. Start the jointer.

7. Press the workpiece against the table and fence with firm pressure. Use your trailing hand to guide the workpiece through the cut, and feed the workpiece over the cutterhead.

   Note: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place it on the portion of the workpiece that is over the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

8. Repeat **Step 7** until the entire edge is flat.

Bevel Cutting

The purpose of bevel cutting is to cut a specific angle into the edge of a workpiece (see **Figures 37 & 38**).

The Model G0675 has preset fence stops at 45˚ outward and 90˚. If your situation requires a different angle, the preset fence stops can be easily adjusted for your needs.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.

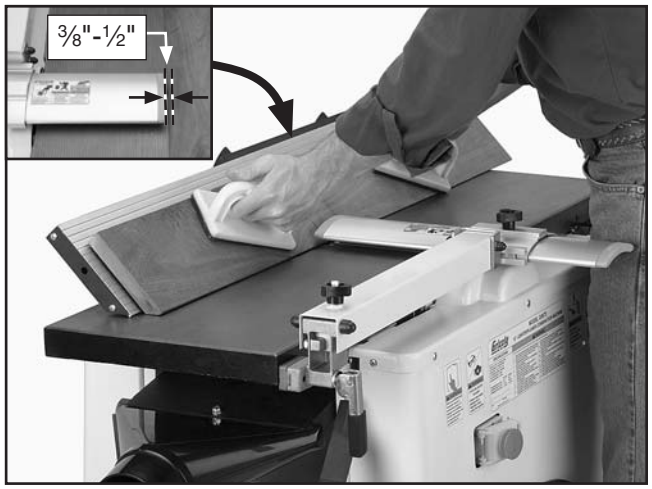


Figure 37. Bevel cutting operation.

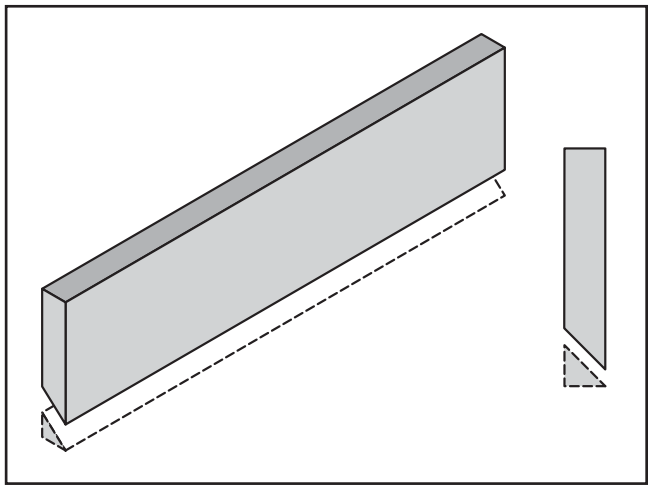


Figure 38. Illustration of bevel cutting results.

To bevel cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 24.**

3. Set the cutting depth for your operation. (We suggest between 1/16" and ⅛" for bevel cutting, using a more shallow depth for hard wood species or for wide stock.)

4. Make sure your fence is set to the angle of your desired cut, adjust the blade guard ⅜" to ½" away from the workpiece (see **Figure 37**), then tighten the blade guard lock knob.

5. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.

6. Start the jointer.

7. With a push block in your leading hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.

   Note: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

8. Repeat **Step 7** until the angled cut is satisfactory to your needs.

Thickness Planer Operation

The Model G0675 planer table moves approximately 1/16" with one full turn of the handwheel. Each graduated mark on the table height handwheel represents 0.001" movement.

To use the planer:

1. Put on safety glasses.

2. Unless your workpiece is very flat, surface plane the workpiece on the jointer until it is flat—having the face flat will ensure that it sits flat on the planer table during operation.

3. Adjust the table height to slightly lower than your workpiece height to ensure the first cut is as light as possible (approximately 1/32"–1/16") .

4. Start the planer.

5. Place the flat side of the board down on the table (on the left side, facing the front of the machine), and feed the workpiece through the planer—in the opposite direction as when jointing (see **Figure 39**). Make sure not to stand directly in front or behind the workpiece to avoid kickback injury.

Figure 39. Planer operation.

—If the cut is too heavy and bogs down the planer, turn the planer ***OFF*** immediately, allow it to come to a complete stop, remove the workpiece, and repeat **Steps 3–5**.

6. Support the workpiece as it leaves the outfeed end of the planer to reduce snipe.

7. Measure your workpiece thickness and adjust the table height as necessary to take a lighter or heavier pass, depending on your needs. For most wood types, 1/16" per pass is a good cutting depth.

   Note: *Any time you switch directions with the table height handwheel, there will be a small amount of backlash—so the first crank of the handwheel after switching directions will be slightly less than 1/16". However, as long as you move the handwheel in the same direction during operation, backlash will not be a factor.*

SECTION 5: ACCESSORIES

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 40. Recommended products for protecting unpainted cast iron/steel parts on machinery.

G1738—Rotacator™ Precision Planer Tool
The Rotacator is a dial indicator on a magnetic base and is designed for quickly and accurately setting the critical tolerances needed when adjusting any planer, so that nasty surprises such as non-parallel and chattered cuts can be eliminated. A great setup tool for other machines! Accurate to 0.001". Indicator rotates 360˚.

Figure 41. Rotacator™ Precision Planer Tool.

Call 1-800-523-4777 To Order

G9643—8" Precision Straightedge
G9644—12" Precision Straightedge
H2675—16" Precision Straightedge
Ideal for aligning your outfeed bed to the cutterhead and calibrating your depth scale. These grade 00 heavy-duty stainless steel straightedges are manufactured to DIN874 standards for professional results in set-up and inspection work.

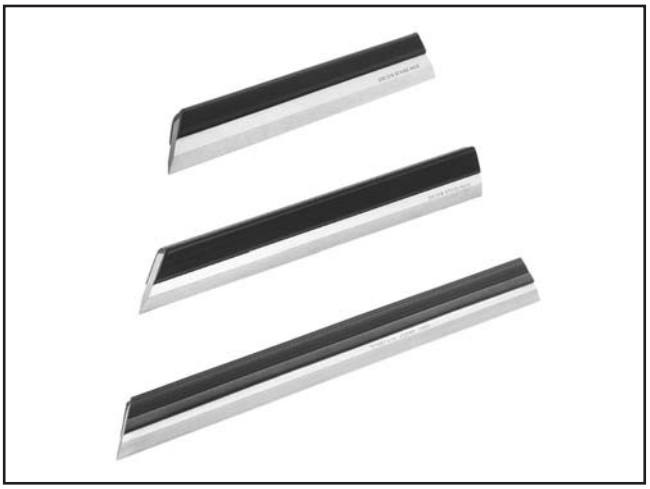
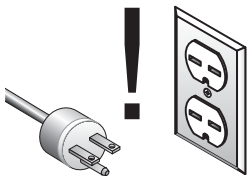


Figure 42. Straightedges.

T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20448—Economy Clear Safety Glasses
T20452—"Kirova" Anti-Reflective Glasses
T20456—"Dakura" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
These glasses meet ANSI Z87.1-2003 specifications. Buy extras for visitors or employees. You can't be too careful with shop safety!

Figure 43. Our most popular eye protection.

SECTION 6: MAINTENANCE



⚠WARNING
Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

First 3–5 Hours of Operation
- Re-tension belts.
- Lubricate elevation lead screws (**Page 35**).

Daily Check:
- Clean unpainted cast iron parts of jointer and planer tables.
- Clean cutterhead.

Every 20 Hours of Operation
- Lubricate elevation lead screws (**Page 35**).

Every 40 Hours of Operation
- Check and re-tension belts (**on this page**).
- Lubricate cogwheels (**Page 35**).

Monthly Check:
- Lubricate feed roller chain and feed roller sprockets (**Page 35**).
- Lubricate fence (**Page 34**).
- Lubricate outfeed table lock arm and pivot points (**Page 36**).
- Clean/vacuum dust inside planer cabinet.
- Lubricate blade guard arm (**Page 35**).

Semi-Anually
- Lubricate table height chain and planer handwheel linkage (**Page 36**).

Annually
- Lubricate table height chain and planer handwheel (**Page 36**).

Note: *This maintenance schedule is based on average usage. Adjust the maintenance schedule to match your usage to keep your jointer/planer running smoothly and to protect your investment.*

Cleaning

Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth—this ensures moisture from wood dust does not remain on bare metal surfaces. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning. We recommend products like SLIPIT®, G96® Gun Treatment, or Boeshield® T-9 (see **Page 31** for more details).

Belts

V-belt and flat belt removal and replacement involves removing the belts, rolling them off of the pulleys, replacing them with new belts, then re-tensioning them.

Always replace the belts simultaneously, or belt tension may not be even among the belts and may cause premature belt failure.

After the first three hours of operation, re-tension the belts, as they will stretch and seat during this time. Then check and re-tension if necessary after 40 operating hours.

Tools Needed	Qty
Wrenches 10 & 13mm	1 Ea
Hex Wrenches 5 & 6mm	1 Ea

Replacing Flat Drive Belt

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Raise the planer table to about the 6" mark.

3. Remove the four cap screws (**Figure 44**) inside the cabinet on the fence side, then remove the rear access panel.

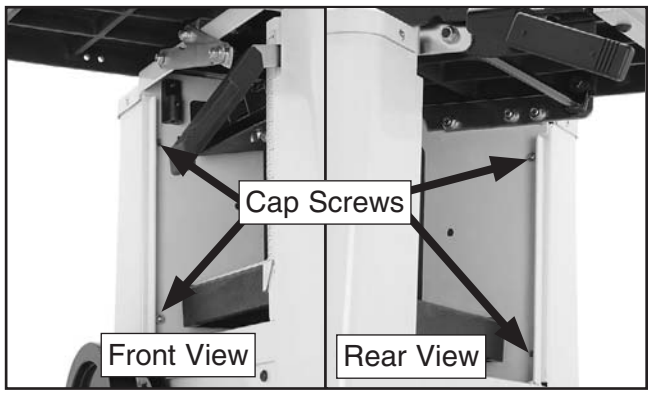


Figure 44. Location of rear access panel screws.

4. Repeat **Step 3** to remove the front access panel.

5. Loosen the locking nuts on both sides of the machine, as shown in **Figures 45** & **46**.

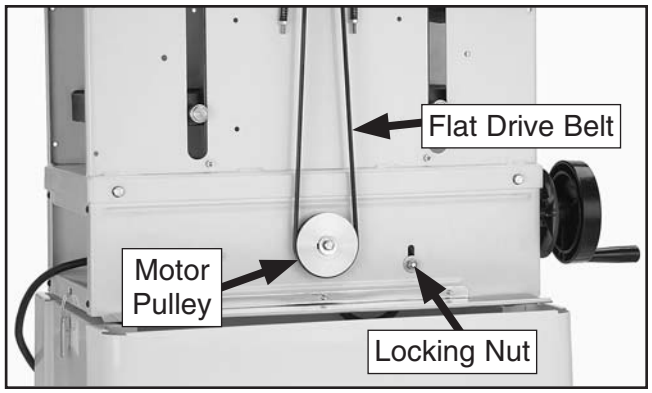


Figure 45. Location of locking nut on rear of machine.

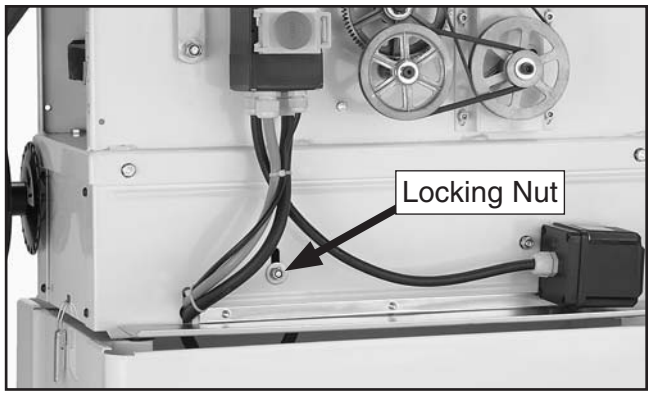


Figure 46. Location of locking nut on front of machine.

6. Squeeze the flat belt in the middle to remove tension, then tighten the locking nut nearby to hold the drive pulley.

7. Remove the flat belt and install the new flat drive belt onto the pulleys.

8. Loosen the locking nut to lower the drive pulley.

9. Tighten both locking nuts and push the flat belt in the center to check belt tension.

   The belt is correctly tensioned when there is approximately ½" deflection when the flat drive belt is pushed with moderate pressure, as shown in **Figure 47**. Continue to **Adjusting /Replacing Feed Cylinder Belts**.

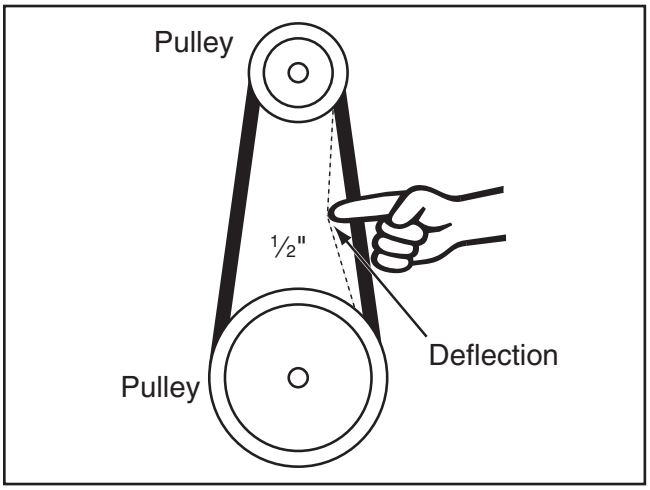


Figure 47. Checking belt tension.

—If there is more than ½" deflection when the flat belt is pushed with moderate pressure, loosen the locking nuts, adjust the motor pulley downward, then tighten the locking nuts. Continue to **Adjusting/Replacing Feed Cylinder Belts**.

Adjusting/Replacing Feed Belts

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Raise the planer table to the 3" mark, remove the four cap screws that secure the front access panel, then remove the panel.

3. Loosen the four cap screws on the wheel bracket, and one cap screw on the infeed belt wheel (see **Figure 48**), then raise the infeed belt wheel.

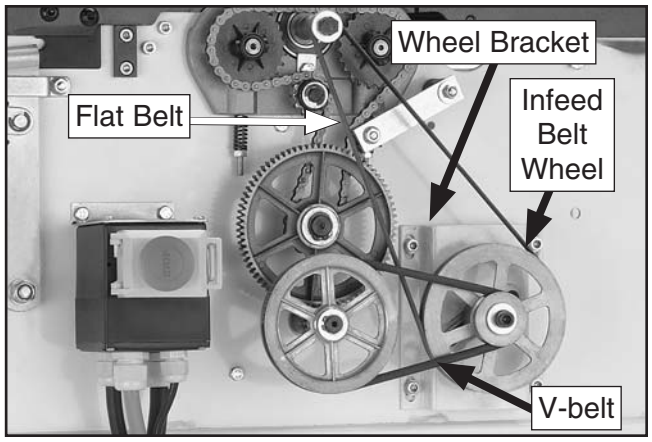


Figure 48. Cap screw locations.

4. Remove the flat belt and V-belt, install a new flat belt and V-belt in the same manner that you removed them.

5. Push the wheel bracket (see **Figure 48**) down and tighten the four cap screws, then push the infeed belt wheel down and tighten the cap screw loosened in **Step 3**.

6. Check the tension of each belt.

   —If there is approximately ½" deflection when the flat belt or V-belt is pushed with moderate pressure, the belts are correctly tensioned.

   —If there is more than ½" deflection when the flat belt or V-belt is pushed with moderate pressure, repeat **Steps 3–5**, then check the tension again.

7. Re-install the front and rear access panels with the cap screws you removed earlier.

Lubrication

An essential step for lubrication is cleaning the components before lubricating them.

This idea is critical because dust and chips build up on lubricated components and make the components hard to move. Simply adding more grease to the components with built-up grime on them will not yield smooth moving components.

Clean the components in this section with an oil/grease soluble cleaner, such as mineral spirits.

The following are the main components that need to be lubricated:

- Fence (**on this page**)
- Blade Guard Arm (**Page 35**)
- Leadscrews (**Page 35**)
- Feed Roller Chain, Sprocket and Cogwheels (**Page 35**)
- Outfeed Table (**Page 36**)
- Table Height Chain (**Page 36**)
- Planer Table Handwheel (**Page 36**)

Schedules are based on average use. Adjust lubrication according to your level of use.

Fence

Clean away any built up grime and debris with a rag and mineral spirits, then place 1-2 drops of light machine oil on the pivot points shown in **Figure 49** once a month. Move the fence through its full range of motion to distribute the oil.

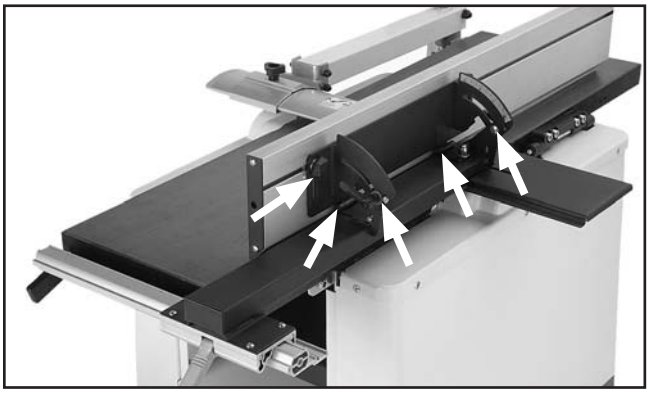


Figure 49. Fence lubrication locations.

Blade Guard Arm

Clean away any built up grime and debris with a rag and mineral spirits, then place 1-2 drops of light machine oil on the points shown in **Figure 50** once a month.

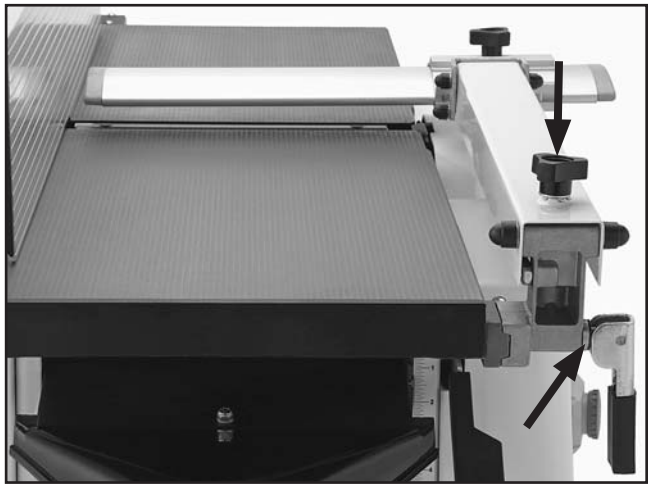


Figure 50. Blade guard arm lubrication locations.

Leadscrews

Clean away debris and built-up grime on the leadscrews with a rag and mineral spirits, then apply a thin coat of SAE 10-30W oil with a clean rag to the four leadscrews in the locations shown in **Figures 51–52** after the first five hours and then every 20 hours. Move the planer table through its full range of motion to distribute the lubricant.

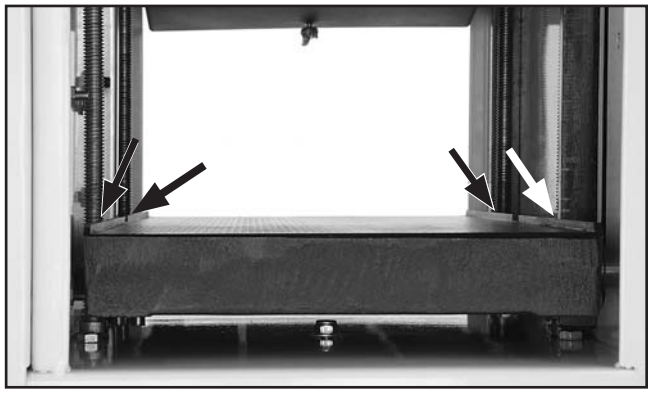


Figure 51. Leadscrew-planer table lubrication locations.

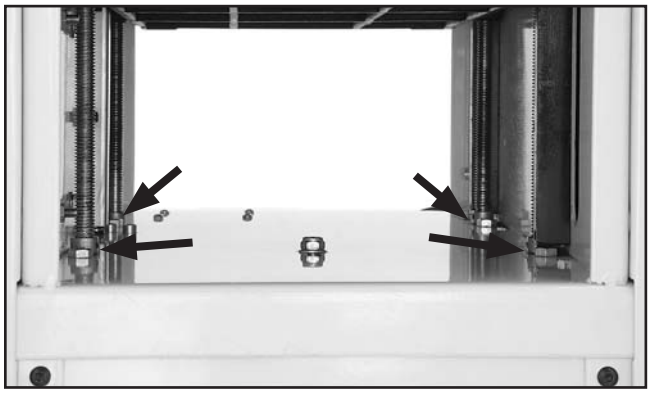


Figure 52. Additional leadscrew lubrication locations.

Feed Roller Chain, Sprocket and Cogwheels

Inspect the feed roller chain and feed roller sprockets monthly. Thoroughly clean debris and grime with a rag and mineral spirits, then use a brush or rag to apply a thin coat of multi-purpose grease when needed, as shown in **Figure 53**. Remove the front panel to access.

Lubricate the cogwheels with a thin coat of multi-purpose grease every 40 operating hours.

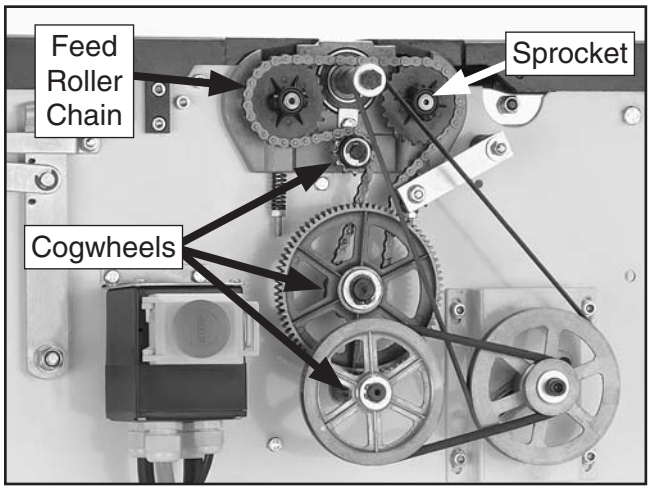


Figure 53. Feed roller chain, sprocket, and cogwheel lubrication locations.

Outfeed Table

Clean debris and grime from the outfeed table lock arm and pivot points, then apply 1-2 drops of light machine oil to the components shown in **Figure 54** once a month.

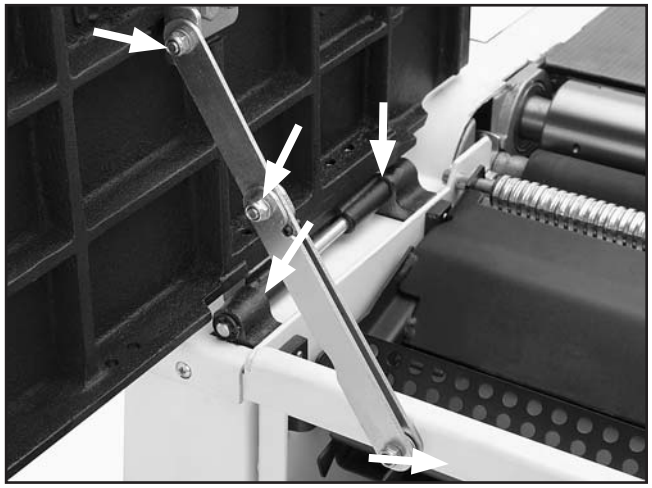


Figure 54. Outfeed table lubrication points.

Table Height Chain & Planer Handwheel

Inspect the table height chain (see **Figure 55**) every six months to a year. Clean away debris and built-up grime on the chain with a rag and mineral spirits, then apply a thin coat of multi-purpose grease. Lubricate the planer table handwheel linkage with light machine oil as needed.

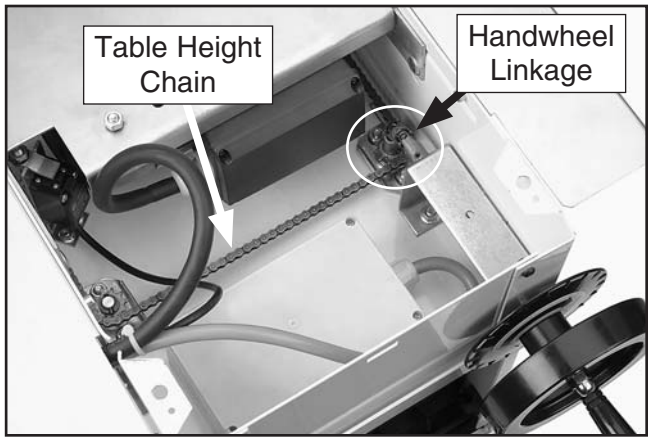


Figure 55. Table height chain and handwheel linkage.

To access the table height chain and planer table handwheel linkage, remove the fence, front and rear access panels, blade guard arm assembly, and rear fence rail. With the help of an assistant, lift the machine off the base, then turn the machine over and place it upside down on blocks, carpet, or cardboard (see **Figure 56**).

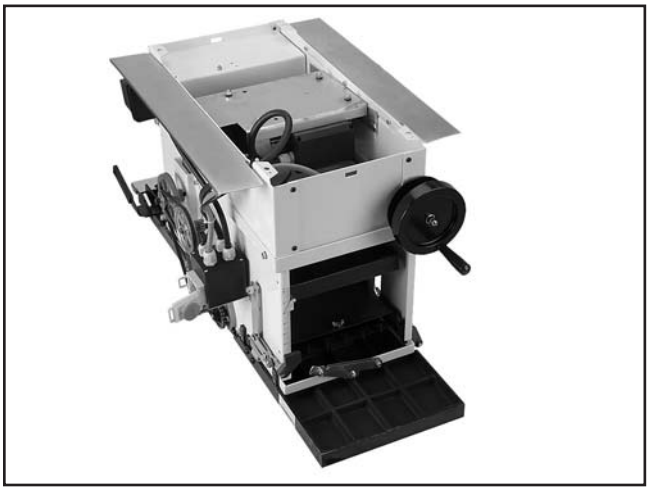


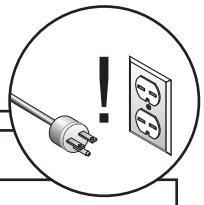
Figure 56. Machine turned over for access to table height chain.

After lubricating the chain and handwheel mechanism, make sure the outfeed table is locked, then reverse the prior steps to reassemble the jointer/planer.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Blown fuse. 2. Power supply switched ***OFF*** or at fault. 3. Plug/receptacle at fault/wired wrong. 4. Start capacitor at fault. 5. Wall circuit breaker tripped. 6. Wiring open/has high resistance. 7. Motor ON/OFF switch at fault. 8. Motor at fault. 9. Dust chute lock not engaged on infeed table (planer operation); outfeed table unlocked and raised up (jointer operation).	1. Replace fuse/ensure no shorts. 2. Ensure power supply is on/has correct voltage. 3. Test for good contacts; correct the wiring. 4. Test/replace if faulty. 5. Ensure circuit size is correct/replace weak breaker. 6. Check/fix broken, disconnected, or corroded wires. 7. Replace switch. 8. Test/repair/replace. 9. Engage the dust chute lock (planer); lock the outfeed table down (jointer).
Machine stalls or is underpowered.	1. Feed rate/cutting speed too fast. 2. Workpiece material not suitable for machine. 3. Machine undersized for task. 4. Belt(s) slipping. 5. Motor wired incorrectly. 6. Plug/receptacle at fault. 7. Pulley/sprocket slipping on shaft. 8. Motor bearings at fault. 9. Machine undersized for task. 10. Motor overheated. 11. Motor at fault.	1. Decrease feed rate/cutting speed. 2. Only cut wood/ensure moisture is below 20%. 3. Use correct blade/reduce feed rate or depth of cut. 4. Tension/replace belt(s); ensure pulleys are aligned. 5. Wire motor correctly. 6. Test for good contacts/correct wiring. 7. Replace loose pulley/shaft. 8. Test/repair/replace. 9. Use sharp knives; reduce feed rate/depth of cut. 10. Clean motor, let cool, and reduce workload. 11. Test/repair/replace.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Knives/gibs at fault. 3. Blade at fault. 4. Belts worn or loose. 5. Pulley loose. 6. Motor mount loose/broken. 7. Machine incorrectly mounted. 8. Motor fan rubbing on fan cover. 9. Motor bearings at fault. 10. Cutterhead bearings at fault.	1. Inspect/replace damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Resharpen/replace knives; set knife alignment/height correctly. 3. Replace warped/bent blade; resharpen dull blade. 4. Inspect/replace belts with a new matched set. 5. Realign/replace shaft, pulley, setscrew, and key. 6. Tighten/replace. 7. Tighten mounting bolts; relocate/shim machine. 8. Fix/replace fan cover; replace loose/damaged fan. 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 10. Replace bearing(s)/realign cutterhead.

Symptom	Possible Cause	Possible Solution
Outfeed table does not lock.	1. Table lock lever engaged when table is being closed.	1. Disengage table lock lever, lower table, then engage lever.
Outfeed table will not close.	1. Table lock arm stuck.	1. Push lock arm pin out; lubricate as needed.
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).	1. Operator pushing down on trailing end of workpiece. 2. Workpiece is not supported as it leaves the planer.	1. Lift up on the trailing end of the workpiece as it enters and leaves the planer. 2. Support the workpiece as it leaves the outfeed end of the planer.
Workpiece stops/ slows in the middle of the cut.	1. Taking too heavy of a cut. 2. Pitch and glue build up on planer components.	1. Take a lighter cut. 2. Clean the internal cutterhead components with a pitch/resin dissolving solvent.
Workpiece feeds erratically.	1. Rubber lining on rubber feed rollers has eroded excessively.	1. Replace feed rollers (**Page 47**).
Chipping (consistent pattern).	1. Knots or conflicting grain direction in wood. 2. Nicked or chipped knife. 3. Taking too deep of a cut.	1. Inspect workpiece for knots and grain direction; only use clean stock. 2. Replace the knife (**Page 43**). 3. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods.)
Fuzzy grain.	1. Wood may have high moisture content or surface wetness. 2. Dull knives.	1. Check moisture content and allow to dry if moisture is too high. 2. Replace the knives (**Page 43**).
Long lines or ridges that run along the length of the board	1. Nicked or chipped knives.	1. Replace knives (**Page 43**).
Uneven knife marks, wavy surface, or chatter marks across the face of the board.	1. Knives not adjusted at even heights in the cutterhead. 2. Worn cutterhead bearings.	1. Adjust the knives so they are set up evenly in the cutterhead (**Page 43**). 2. Replace cutterhead bearings.
Glossy surface. (Planer)	1. Knives are dull. 2. Cutting depth too shallow.	1. Replace the knives (**Page 43**). 2. Increase the depth of cut.
Chip Marks (inconsistent pattern). (Planer)	1. Chips aren't being properly expelled from the cutterhead.	1. Use a dust collection system.
Board edge is concave or convex after jointing. (Jointer)	1. Board not held with even pressure on infeed and outfeed table during cut. 2. Board started too uneven. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes.	1. Hold board with even pressure as it moves over the cutterhead. 2. Take partial cuts to remove the extreme high spots before doing a full pass. 3. Surface plane one face so there is a good surface to position against the fence. 4. It may take 3 to 5 passes to achieve a perfect edge, depending on starting condition of board and depth of cut.

Jointer Table Parallelism

The tables of your jointer MUST be parallel with the cutterhead and each other (see **Figure 57**) to reduce the risk of workpiece kickback and to help ensure good cutting results.

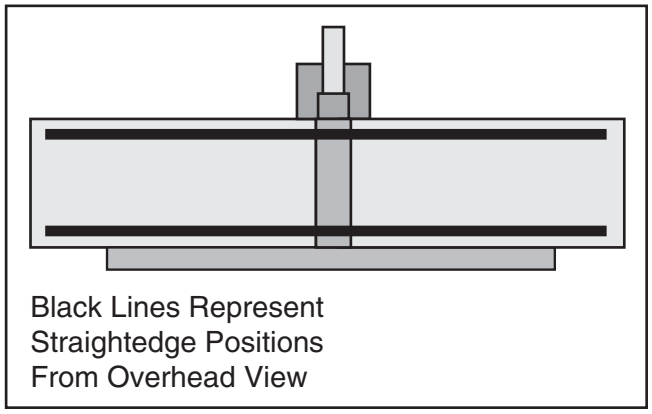


Figure 57. Illustration of table parallelism concept.

Adjusting the tables parallel with each other is a complex and precise task that may take more than an hour to complete.

Due to the complex nature of this task, we recommend that you double check the current table positions to make sure that they really need to be adjusted before starting.

Note: *Typically, a tolerance of ±0.005" in parallelism between the tables is considered acceptable.*

When adjusting table parallelism, you must do the following: 1) properly adjust the outfeed table height and parallelism in relation to the cutterhead, and 2) adjust the infeed table parallel to the outfeed table, and 3) adjust the knives to bring the outfeed table surface and cutting edges of the knives to the same height.

Tools Needed	Qty
Straightedge	1
Hex Wrench 5mm	1
Wrench 13mm	1
Feeler Gauge Set	1
Assistant	1

Checking Outfeed Table Parallelism

The outfeed table is preset by the factory parallel with the cutterhead. However, it is critical to check this setting.

To check outfeed table parallelism:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Remove the blade guard arm assembly.

3. Place the straightedge on the back of the outfeed table so it hangs over the cutterhead as shown in **Figure 58**.

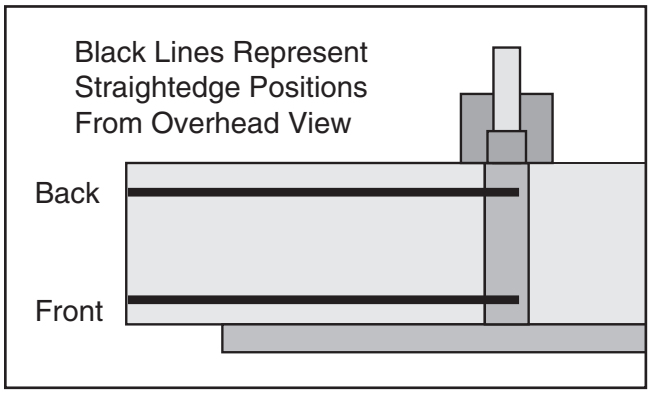


Figure 58. Straightedge positions for verifying if the outfeed table is parallel with the cutterhead.

4. Try to fit a 0.060" feeler gauge (or combination of feeler gauges) between the cutterhead body and the bottom of the straightedge (**Figure 59**).

   Note: *Rotate the cutterhead to make sure the knives do not interfere with proper measurement.*

Note: *The back side of the outfeed table is factory set approximately 0.060" from the cutterhead. The back side of the outfeed table is not adjustable, so any adjustments to parallelism must be made on the front of the outfeed table.*

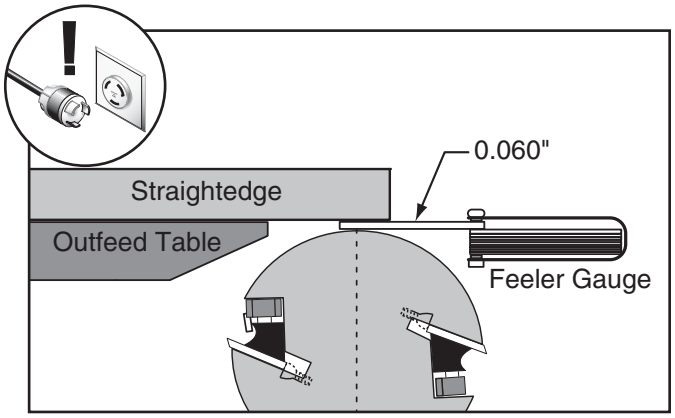


Figure 59. Using feeler gauge to check outfeed table-cutterhead height.

5. Place the straightedge on the front side of the outfeed table so it hangs over the cutterhead, as shown in **Figure 59,** then try to fit a feeler gauge or combination of feeler gauges between the cutterhead and bottom of the straightedge.

—If the feeler gauge slides with slight resistance between the ruler and cutterhead and no gaps appear between the straightedge and the table, then the outfeed table is already parallel with the cutterhead. Go to **Checking Infeed Table Parallelism** on **Page 41**.

—If the feeler gauge does not fit between the ruler and cutterhead, or if there is a gap between the straightedge and the table, the outfeed table is not parallel with the cutterhead. Correct the outfeed table parallelism, then correct the infeed table parallelism. Continue to **Correcting Outfeed Table to Cutterhead Parallelism.**

Correcting Outfeed Table to Cutterhead Parallelism

This procedure involves loosening the outfeed table support blocks and adjusting their height to raise or lower the front of the outfeed table until it is parallel with the cutterhead.

To correct outfeed table parallelism:

1. Loosen the cap screws on both outfeed table support blocks (see **Figure 60**).

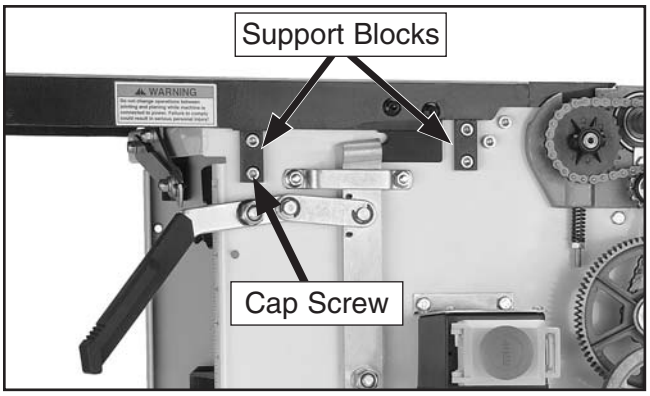


Figure 60. Location of front outfeed table support blocks.

2. Fit the 0.060" feeler gauge (or combination of feeler gauges) onto the front side of the cutterhead, then place the straightedge on the front of the outfeed table and over the feeler gauge.

3. While an assistant holds the feeler gauge and straightedge, adjust the height of each support block until no gaps appear between the straightedge and the table.

4. Tighten the cap screws on the suport blocks to secure the adjustment.

5. Using the straightedge and the 0.060" feeler gauge, verify again that no gaps appear between the table and the straightedge.

6. Repeat **Steps 1–5** until the front outfeed table parallelism is correct, then repeat **Checking Outfeed Table Parallelism** on **Page 39** to ensure the outfeed table height above the cutterhead is equal across the table.

7. Continue to **Checking Infeed Table Parallelism** on **Page 41.**

Checking Infeed Table Parallelism

1. Follow all the steps for checking the outfeed table parallelism to first make sure that the outfeed table is parallel with the cutterhead.

2. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in **Figure 61**.

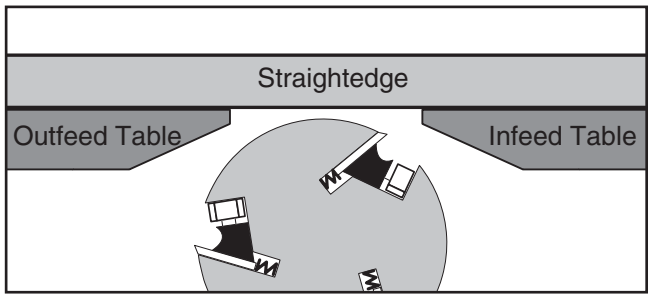


Figure 61. Infeed and outfeed tables set evenly.

—If a knife touches the straightedge, turn the cutterhead so the knives do not interfere.

3. Place the straightedge in the positions shown in **Figure 62**. In each position, the straightedge should sit flat against both the outfeed table and the infeed table—you should not see any gaps between the bottom of the straightedge and the infeed table.

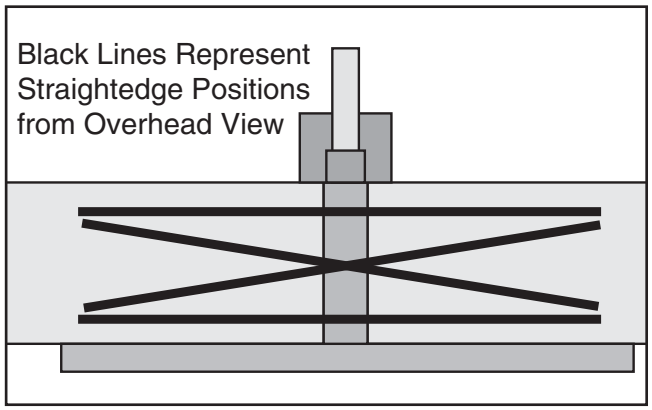


Figure 62. Straightedge positions for checking infeed/outfeed table parallelism.

—If the straightedge sits flat against both the infeed and outfeed table, then the tables are parallel. Continue to **Inspecting Knives** on **Page 42**.

—If the straightedge does not sit flat against both the infeed and outfeed table in any of the positions, then continue to the **Adjusting Infeed Table Parallelism** instructions.

Adjusting Infeed Table Parallelism

1. Perform the "Checking/Adjusting Table Parallelism" procedure on **Page 39**, including making any necessary adjustments so the cutterhead and outfeed table are parallel.

2. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in **Figure 61**.

3. Place the straightedge in one of the positions shown in **Figure 62**.

—If the front of the infeed table is higher or lower than the outfeed table, or if the rear of the infeed table is higher or lower than the outfeed table, continue to **Step 4**.

—If the straightedge sits flat against both the infeed and outfeed table, then the tables are parallel. Continue to **Inspecting Knives** on **Page 42**.

Continued on next page →

4. Loosen the eight hex bolts and flange nuts on both sides of the infeed table, as shown in **Figures 63** and **64**.

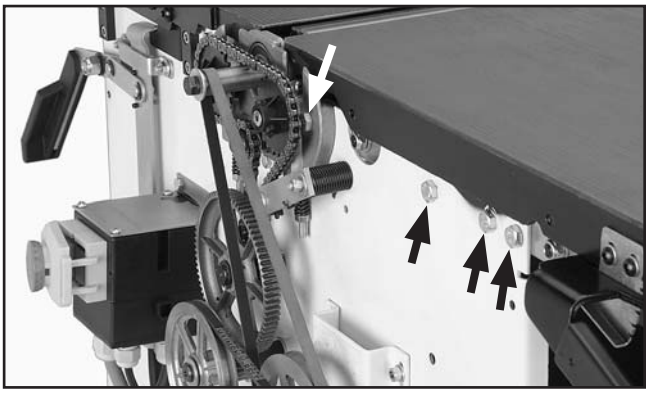


Figure 63. Location of infeed table adjustment bolts, front view.

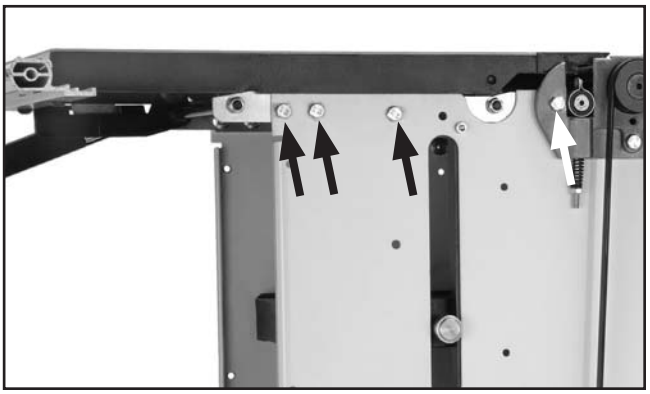


Figure 64. Locations of the infeed table adjustment bolts.

5. While an assistant holds the straightedge over both tables, lift or lower the infeed table, then tighten the hex bolts and nuts as needed so there is little to no visible gap between the bottom of the straightedge and the top of the infeed table.

6. Continue adjusting the infeed table until it is parallel with the outfeed table in each of the positions shown in **Figure 62**. Some trial and error and a good deal of patience will be needed to successfully accomplish this adjustment.

   Tip: *Tighten the front and rear bolts finger tight and tap the table up or down. This will help dial in the adjustment.*

7. Once the infeed and outfeed tables are parallel with each other, proceed to **Inspecting Knives**.

Inspecting Knives

Tools Needed:	**Qty**
Knife Setting Gauge	1
Straightedge	1

The height of the knives can be inspected with the included knife setting gauge.

Inspecting the height of the knives ensures that they are set evenly with the outfeed table at their highest point in the cutterhead rotation.

To inspect the knives with the knife setting gauge:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Perform **Steps 2–7** in **Setting Outfeed Table Height** on **Page 17**.

   —If the top of the knife just touches the bottom of the gauge when it is at the highest point of rotation on both sides of the cutterhead, then that knife is set correctly. (Repeat this inspection with the other knife.)

   —If the top of the knife does not touch the bottom of the gauge as described, then reset that knife. Continue to **Adjusting/ Replacing Knives on Page 43** (Repeat this inspection with the other knife before resetting.)

3. REPLACE the front access panel and the blade guard assembly!

Adjusting/Replacing Knives

Tools Needed:	Qty
Straightedge	1
Hex Wrench 5mm	1
Wrench 8 mm	1

Setting the knives correctly is crucial to the proper operation of the jointer/planer and is very important in keeping the knives sharp. If one knife is higher than the others, it will do the majority of the work, and thus, dull much faster than the others.

Knife Setting Gauge Method: The gauge is placed on the outfeed table over the cutterhead, as shown in **Figure 65**, and the knife heights are set to just touch the gauge. The knife setting gauge makes it easy to ensure that the knives project out of the cutterhead evenly.

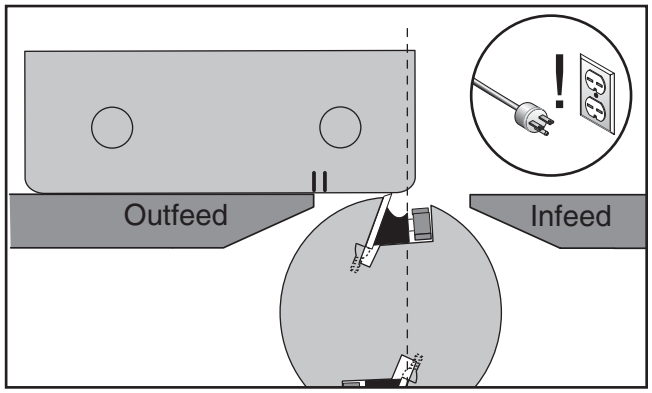


Figure 65. Using knife setting gauge to set knife height.

The Model G0675 comes with jack screws for cutterhead adjustments (see **Figure 66**).

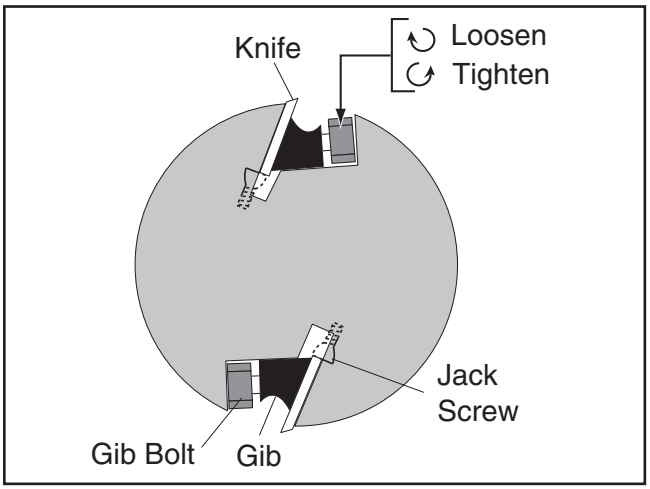


Figure 66. Cutterhead profile diagram.

To set or replace the knives:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Remove the blade guard and fence from the table.

3. Remove the rear access panel to expose the cutterhead pulley.

4. Rotate the cutterhead pulley to give you good access to one of the cutterhead knives.

5. Loosen the cutterhead gib bolts, starting in the middle and alternating back-and-forth until all of the gib bolts are loose but not falling out.

   —If this is the first time you are setting the knives, or if you are replacing them, remove a gib and knife from the cutterhead. Clean the gib and clean inside the cutterhead slot to remove all pitch or sawdust. Coat the knife and gib with a metal protectant (**Page 31**).

6. Position the knife gauge over the knife as shown in **Figure 65** and loosen the gib bolts until the knife is completely loose.

7. Using a 5mm hex wrench, rotate the jack screws (**Figure 67**) in the access holes to raise or lower the knife. When the knife is set correctly, it will barely touch the bottom edge of the knife setting gauge on both sides of the cutterhead when it is rotated back and forth. Snug the gib bolts tight enough to just hold the knife in place. Repeat **Steps 5-7** with the remaining knife.

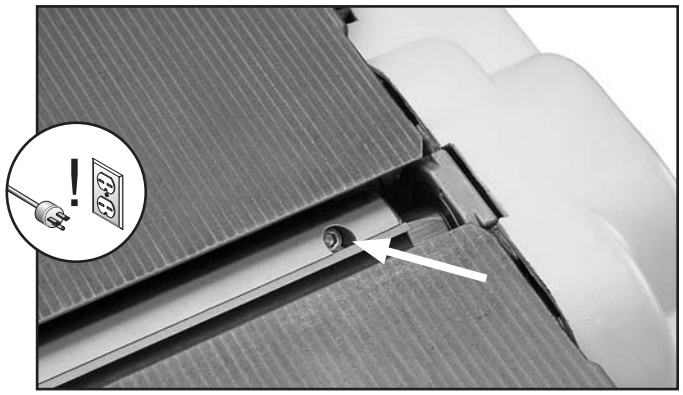


Figure 67. Jack screw access hole.

8. Rotate the cutterhead to the first knife you adjusted. Slightly tighten all the gib bolts, starting at the middle and working your way to the ends by alternating left and right (**Figure 68**). Repeat this step on the remaining knife.

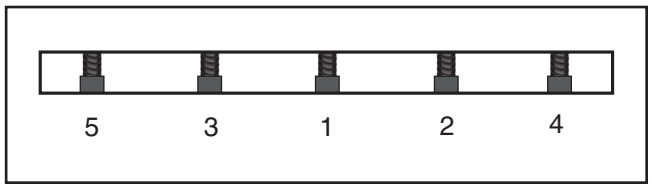


Figure 68. Gib bolt tightening sequence.

9. Repeat **Step 8**, but final tighten each gib bolt.

10. Replace the rear access panel, blade guard, and fence.

Setting Fence Stops

The fence stops simplify the task of adjusting the fence to 45˚ and 90˚.

Tools Needed	Qty
45° Square	1
90° Square	1
Sliding Bevel	1
Hex Wrench 3mm	1
Hex Wrench 7mm	1

Refer to **Figures 69-70** to identify the 90˚ and 45˚ fence stop components.

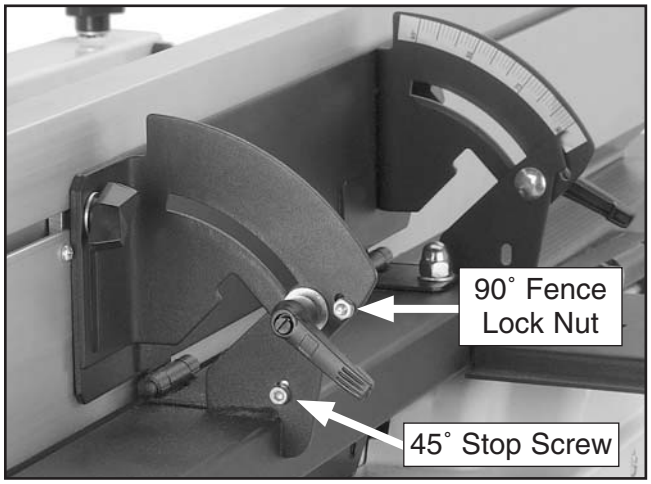


Figure 69. 90˚ lock nut and 45˚ stop screw.

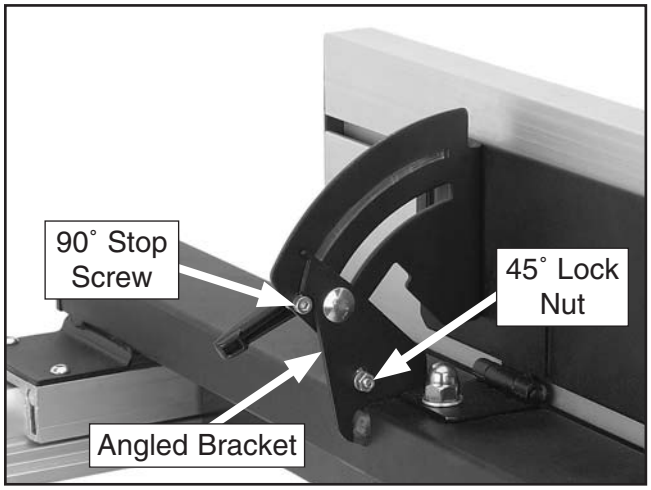


Figure 70. 90˚ stop screw and 45˚ lock nut.

To set the 90˚ fence stop:

1. Loosen the 90˚ lock nut (**Figure 69**) and stop screw (**Figure 70**), and loosen the fence tilt locks.

2. Using a 90˚ square, adjust the fence to the 90˚ position, as shown in **Figure 71**.

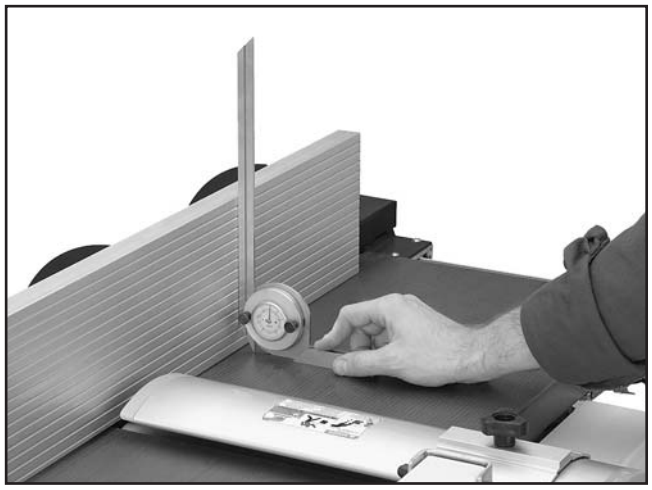


Figure 71. Adjusting fence to 90˚.

3. Adjust the 90˚ stop screw until it contacts the angled bracket on the fence, then tighten the lock nut.

To set the 45˚ fence stop:

1. Loosen the 45˚ lock nut (**Figure 70**) and stop screw (**Figure 69**), then loosen the fence tilt locks.

2. Move the blade guard out of the way, loosen the fence height lock knobs, then slide the fence down until it is flush with the table.

3. Using a 45° square, adjust the fence to the 45° outward position (**Figure 72**).

Figure 72. Adjusting fence 45˚ outward.

4. Secure the 45° stop screw and lock nut against the angled bracket, then tighten the lock nut.

Spring Tension

Feed roller spring tension must be adjusted so that feed roller pressure is uniform for planer operation. Roller spring tension will vary, depending on the type of wood you plane. This is usually determined from trial-and-error.

Generally speaking, less spring tension is more forgiving on workpieces. Therefore, if you primarily plane milled lumber with relatively consistent surfaces, you can get away with having less spring tension. If you mainly plane rough lumber with inconsistent surface heights, more spring tension is a must to keep the workpiece feeding through the planer without stopping.

If workpieces regularly stop feeding during operation, it may be a sign of weak spring tension.

Tools Needed:	**Qty**
Hex Wrench 5mm	1
Wrench 10mm	1

To adjust feed roller spring tension:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Set up the machine for planer operations, remove the cap screws that secure the front and back access panels to the frame (see **Figure 44** on **Page 33**), then remove the panels.

3. Move the chain tensioner away from the chain and place a 5mm hex wrench into the hole in the frame, as shown in **Figure 73**, to hold the tensioner and de-tension the chain.

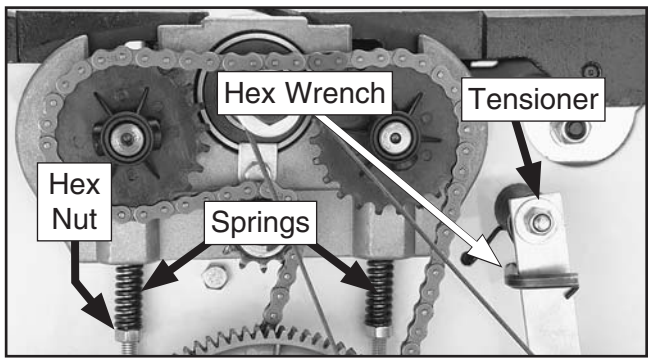


Figure 73. Location of adjustments nuts (front panel removed for access).

4 Locate the hex nuts and springs on both sides of the feed rollers, as shown in **Figure 73**.

5. Adjust the hex nuts so they are at the recommended factory setting—½" (13mm) from the bottom of the feed roller bolts (see **Figure 74**).

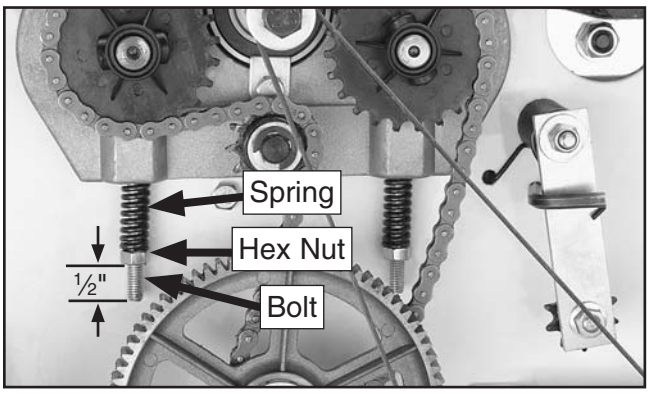


Figure 74. Recommended chain tension setting.

6. Remove the hex wrench, move the tensioner back to re-tension the chain, the re-install the front and rear panels with the cap screws you removed earlier.

7. Run a test board through the planer.

—If the workpiece slips when you feed it, repeat **Steps 1-4**, then turn the hex nuts ½ to 1 turn clockwise to increase spring tension. Continue to **Step 8**.

—If the workpiece is abruptly grabbed when initially fed into the planer, repeat **Steps 1-4,** then turn the hex nuts ½ to 1 turn counterclockwise to decrease spring tension. Continue to **Step 8**.

—If the workpiece feeds smoothly, the spring tension is correct.

8. Repeat **Steps 6-7**, and continue adjusting the spring tension until it is right for the type of wood you are planing.

Replacing Feed Rollers

After long term use of the jointer/planer the rubber coating on the feed rollers may wear, resulting in workpieces feeding erratically. When this happens, replace both the front and rear feed rollers as a set.

Tools Needed:	**Qty**
Hex Wrench 4mm	1
Wrench 13mm	1
Wrench 10mm	1

To replace the front and rear feed rollers:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Remove the eight cap screws that secure the front and rear access panels to the frame (see **Figure 44** on **Page 33**), then remove the panels.

3. Remove the four special bolts and washers that secure the infeed table to the frame, then remove the infeed table (see **Figure 75**).

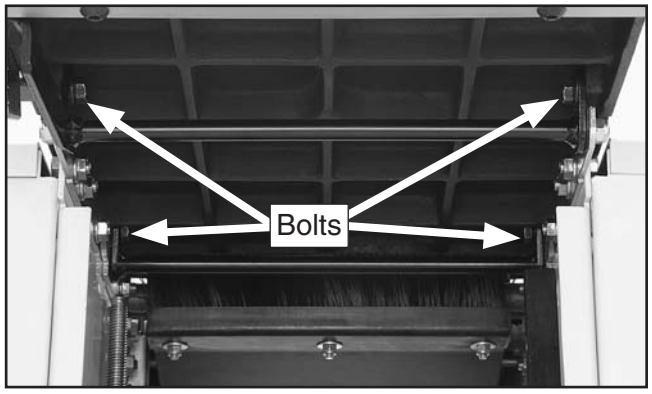


Figure 75. Location of bolts that secure infeed table.

4. Move the chain tensioner away from the chain and place a 5mm hex wrench into the hole in the frame, as shown in **Figure 73** on **Page 46**, to hold the chain tensioner and keep the chain detensioned.

5. Loosen the four cap screws on the wheel bracket, and one cap screw on the infeed belt wheel, raise the infeed wheel and roll the flat belt off (see **Figure 76**).

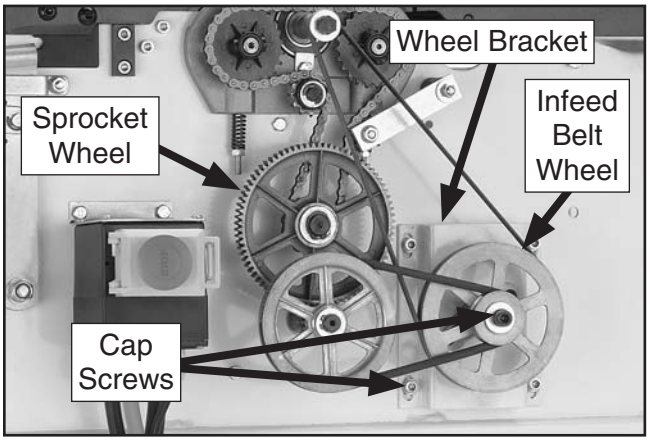


Figure 76. Wheel bracket cap screws.

6. Remove the hex nuts and springs (see **Figure 73** on **Page 46**) from both sides of the front and rear feed rollers.

7. While rotating the lower sprocket wheel clockwise, walk the chain off of the front feed roller sprocket (**Figure 77**), then remove the chain from both feed roller sprockets.

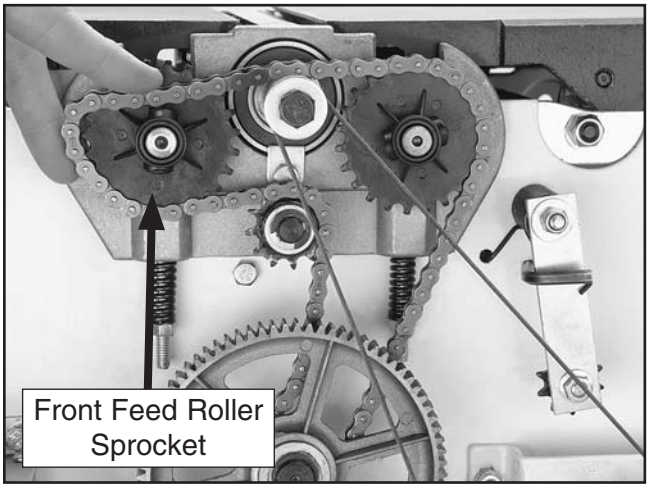


Figure 77. Removing feed roller chain.

8. Raise the outfeed table and engage the lock arm.

9. Remove the front and rear feed rollers, then install the new feed rollers.

10. Close and lock the outfeed table.

11. Place the chain back onto the feed roller sprockets, rolling it on in the same manner that you removed it in **Step 7**.

12. Re-install the springs and hex nuts onto both sides of the new feed rollers, tightening the nuts until they are ½" (13mm) from the bottom of the bolts, as shown in **Figure 74** on **Page 46**.

13. Remove the hex wrench to re-tension the chain.

14. Re-install the flat belt, making sure that it is seated into the infeed wheel grooves, then secure the cap screws on the wheel bracket and the infeed belt wheel.

15. Check the flat belt tension (refer to **Page 33**, **Step 6**).

16. Re-install the infeed table with the bolts and washers you removed earlier, and reinstall the side panels with the cap screws.

Chain Tension

The chain drive transfers movement from the handwheel to elevate the headstock. The chain drive can be adjusted to remove slack if the chain stretches over time or is loosened during table leveling procedures.

This procedure will require you to remove the jointer/planer assembly from the base to adjust the chain tension.

Tools Needed:	**Qty**
Wrench or Socket 13mm	2
Forklift	1
Sawhorses	2

To adjust the chain tension:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Perform **Steps 2–7** in the **Table Parellelism Adjustments** subsection on **Page 50**, except you will not need to remove the side panels—unless you plan to check table parallelism after checking chain tension.

NOTICE

During the next step, DO NOT let the chain fall off the sprockets—returning it to its proper location without changing the table adjustments can be very difficult.

3. Loosen the two lock nuts on the idler sprocket (**Figure 78** and **79**) and move the sprocket behind the chain to tighten it.

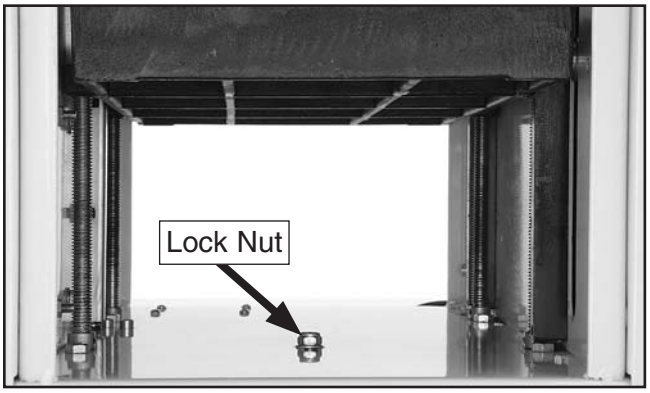


Figure 78. Top idler sprocket lock nut (viewed from planer table infeed side).

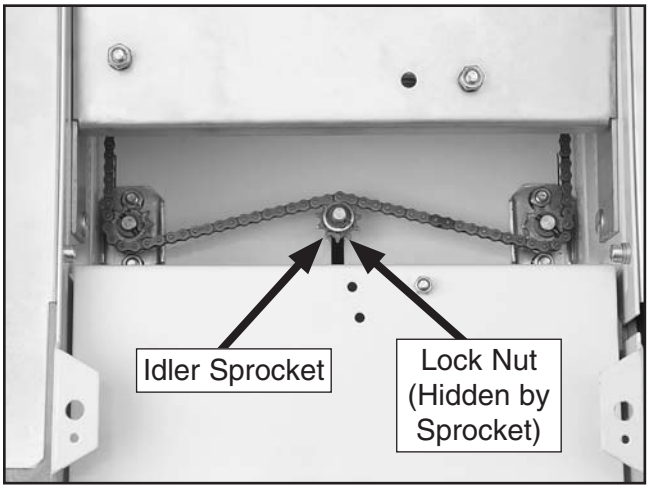


Figure 79. Underside of table and idler sprocket.

4. Using the forklift, place the table back on the base, and relatch the base to the jointer/planer.

Planer Table Parallelism

Table parallelism is critical to the operation of the machine. As such, it is essential that the table is parallel with the cutterhead (within 0.003") from side-to-side, as illustrated in **Figure 80**.

Maximum Allowable Tolerances:
Cutterhead to Table Side-to-Side.....0.003"
Headstock to Table Front/Back.....0.040"

Tools Needed:	**Qty**
Rotacator	1
Standard Screwdriver	1
Wrench or Sockets 13mm	2
Hex Wrench 5mm	1
Sawhorses	2
Assistant	1
Forklift	1
White Marker or Correction Fluid	Varies

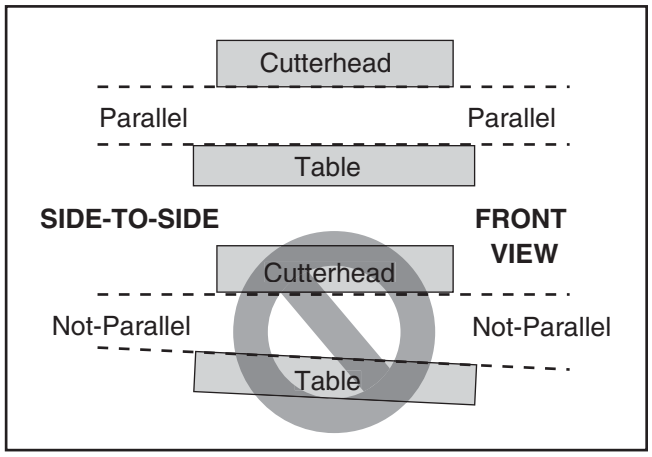


Figure 80. Side-to-side parallelism of table and cutterhead.

How the table sits in relation to the base from front-to-back is also important (see **Figure 81**). The tolerances on the front-to-back positioning are not as critical as the cutterhead/table side-to-side positioning. Therefore, the maximum allowable tolerance for the front-to-back parallelism is not more than 0.040".

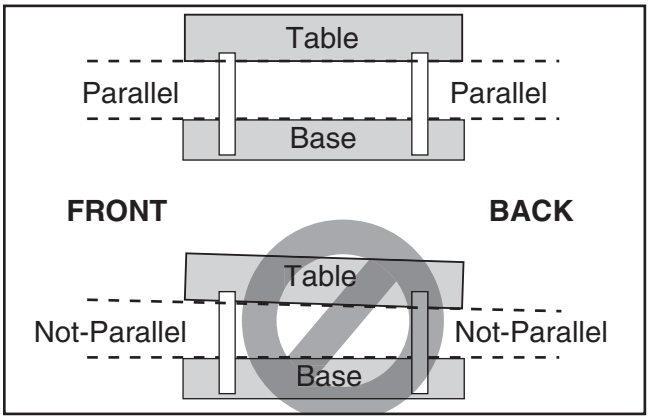


Figure 81. Front-to-back parallelism.

Table Parallelism Inspection

The easiest way to determine if your planer table has a parallelism problem with the base is to plane a workpiece and measure the thickness in multiple locations. If the workpiece is tapered from left-to-right or from front-to-back, then parallelism may be a problem.

Use your Rotacator (**Page 31**) to further inspect the table parallelism, as shown in **Figure 82** and **Figure 83** on **Page 50**.

To inspect the cutterhead-table parallelism:

1. Place the jointer outfeeed table in the upright position, then rotate the dust chute assembly up and over the cutterhead to access the cutterhead and planer table below.

2. Place the Rotacator on the planer table under one side of the cutterhead, then raise the planer table until the dial rotates one full turn to "0" (see **Figure 82**).

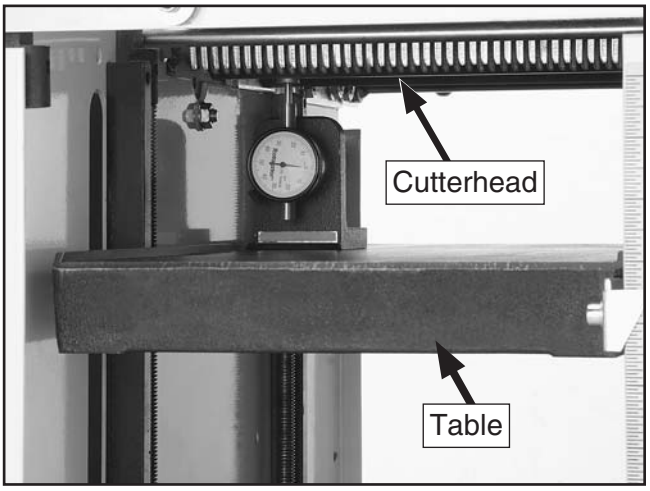


Figure 82. Measuring side-to-side parallelism.

3. Rock the cutterhead back and forth and rotate the cutterhead until the dial is at "0".

4. Move the Rotacator to the same position on the oppposite side of the table and note the reading.

5. Place the Rotacator on the base under the center of the infeed side of the planer table, so the plunger contacts the webbing evenly (see **Figure 83**).

6. Lower the table and zero out the Rotacator.

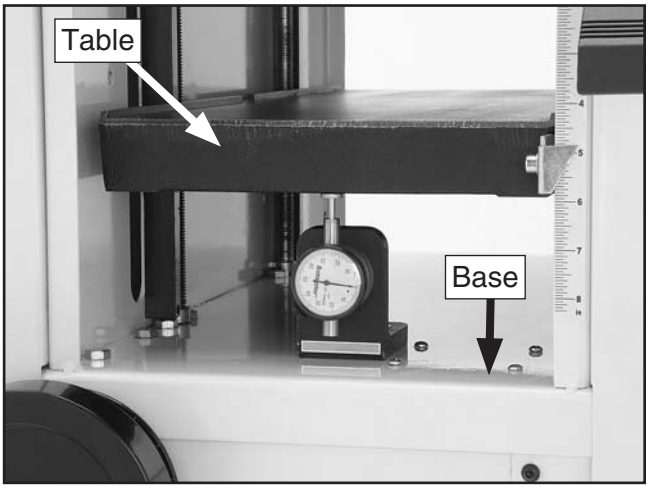


Figure 83. Measuring front-to-back parallelism.

7. Move the Rotacator to the same position under the outfeed side of the planer table and note the reading.

If you do not have a Rotacator, a wood block and feeler gauges may be used, but extra care must be taken to ensure accuracy. If the table is not within the maximum allowable tolerances, it must be adjusted.

Table Parallelism Adjustments

The table is adjusted by turning the chain sprockets underneath the base. This procedure can take a great deal of patience and time.

To adjust the table parallelism:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Convert the machine for jointer operations, then remove the fence, fence arm assembly, and lock the outfeed table.

3. Remove the front and rear access panels, then unlatch the jointer/planer assembly from the base.

4. Place sawhorses about 16 inches apart.

5. Place forklift forks under both tables, making sure they do not contact the outfeed table lock lever or the infeed table height lever, but enough so the machine does not slide off of the forks.

6. While an assistant steadies the jointer tables, lift the machine off of the base and set it onto the sawhorses, as shown in **Figure 84**.

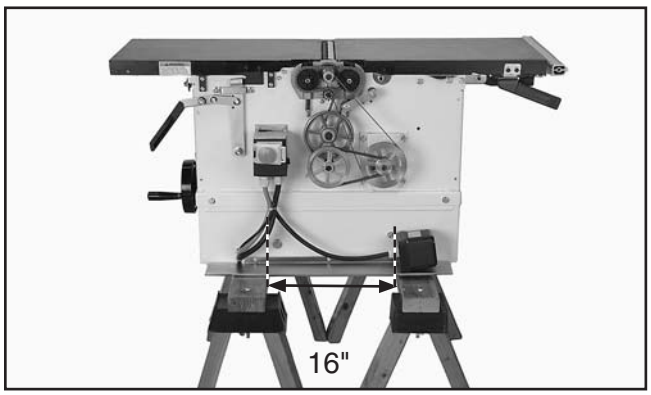


Figure 84. Machine supported by sawhorses.

7. Locate the chain on the underside of the table.

8. Loosen the idler sprocket (see **Chain Tension** instructions on **Page 48**).

9. Mark the location of one tooth in the sprocket that you are adjusting.

10. Move the chain away from only the sprocket you want to adjust so only that sprocket can be turned independent of the chain.

    Note: *If the left side of the table is too high (viewed from the planer table infeed), the front and rear left sprockets will need to be adjusted. Each tooth on the sprocket represents .007" of vertical movement as the cogs are turned. Make sure, as you turn the sprockets, to keep an accurate tooth count to ensure that the table is adjusted equally.*

11. Carefully turn the sprocket (clockwise to lower the table; counterclockwise to raise the table) just enough to position the next tooth at the marked location, then fit the chain around sprocket again.

12. Repeat **Steps 9–11** with each sprocket that needs to be adjusted until the table-to-cutterhead clearance is within 0.007" from one side to the other.

13. Make sure the chain is properly fitted on the sprockets, and tighten the idler sprocket lock nuts.

14. Place the table back on the base with the forklift, relatch the base to the jointer/planer, and reinstall the access panels.

Anti-Kickback Fingers

The Model G0675 provides an anti-kickback system as a safety feature. The anti-kickback fingers hang from a rod suspended across the cutterhead casting. The anti-kickback fingers should be inspected regularly.

Check the fingers (**Figure 85**) to ensure that they swing freely and easily. If the fingers do not swing freely and easily, clean them with a wood resin solvent.

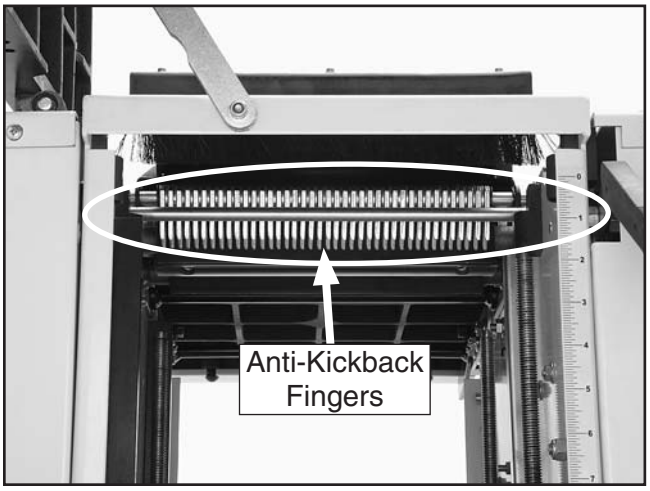


Figure 85. Anti-kickback fingers.

⚠WARNING

Proper operation of the anti-kickback fingers is essential for the safe operation of this machine. Failure to ensure that they are working properly could result in serious operator injury.

Do not apply oil or other lubricants to the anti-kickback fingers. Oil or grease will attract dust, restricting the free movement of the fingers.

SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

⚠WARNING
Wiring Safety Instructions

1. **SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

2. **QUALIFIED ELECTRICIAN.** Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.

3. **WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

4. **MODIFICATIONS.** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

5. **CIRCUIT REQUIREMENTS.** You MUST follow the requirements on **Page 10** when connecting your machine to a power source.

6. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

7. **WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.

8. **CAPACITORS.** Some capacitors store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on capacitors.

9. **EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Overview

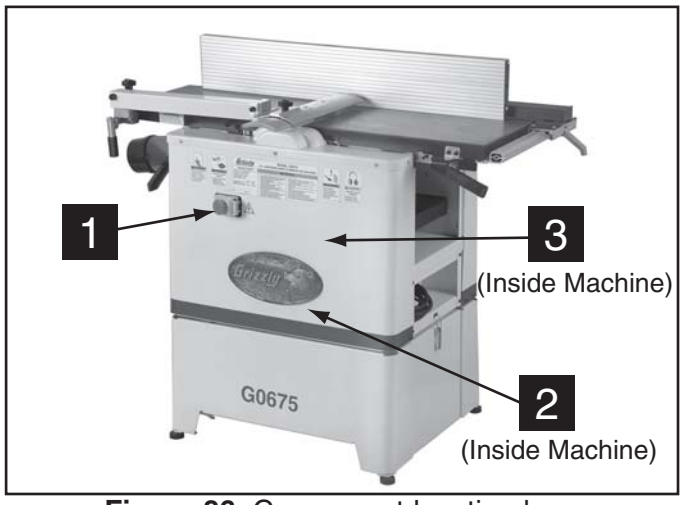


Figure 86. Component location key.

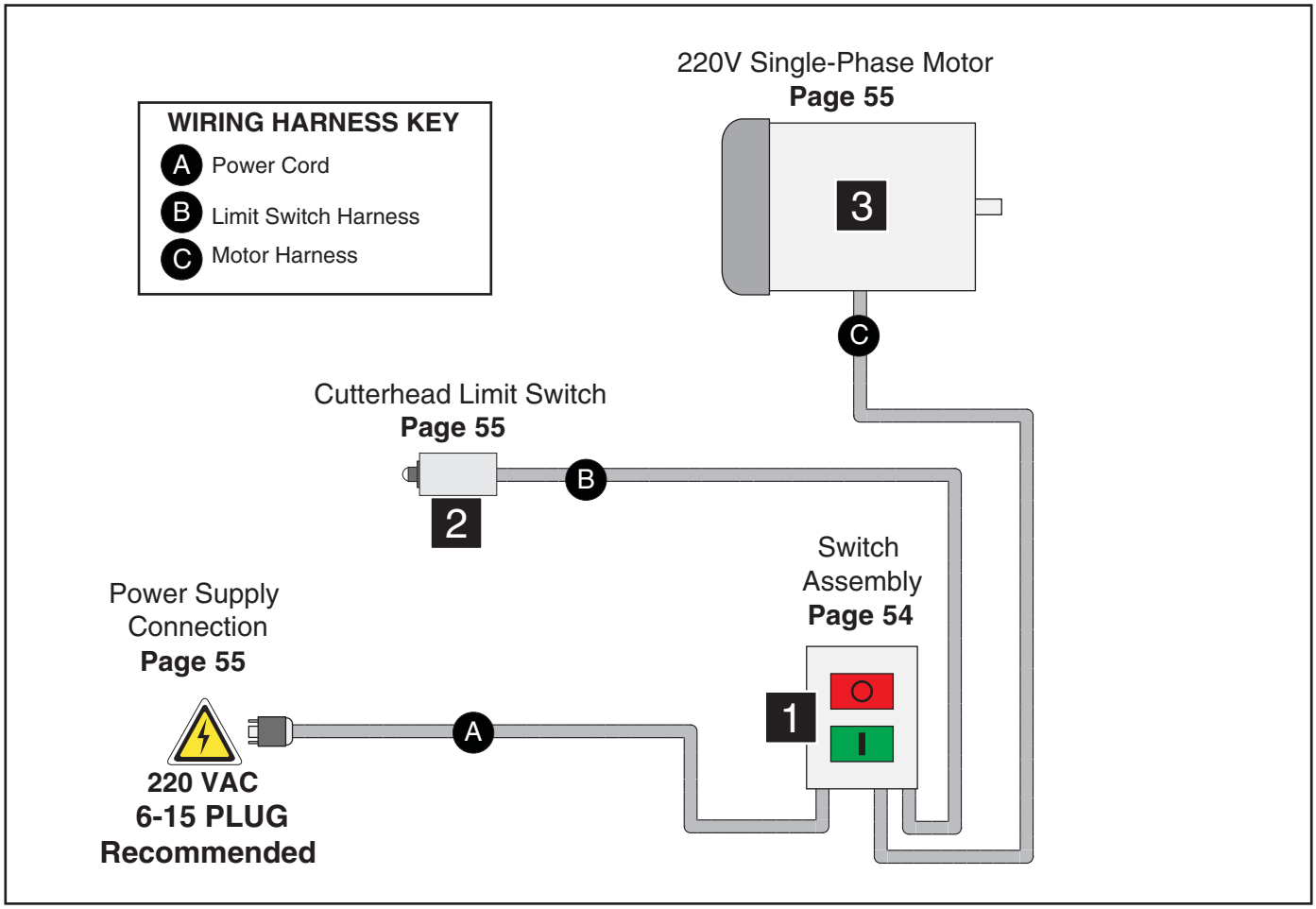


Figure 87. Wiring overview.

ON/OFF Switch Assembly Wiring

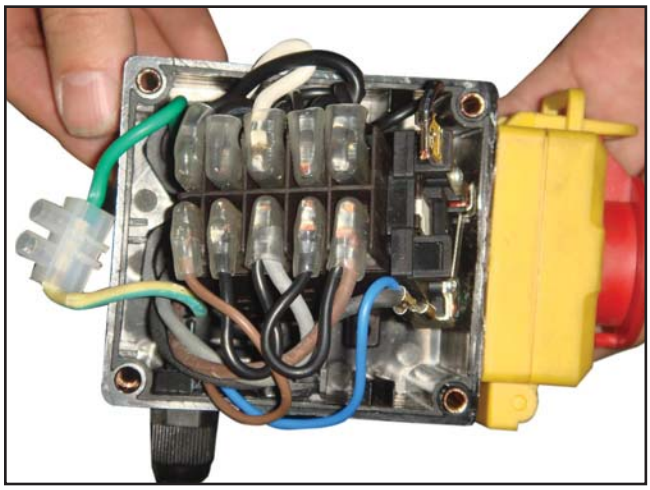


Figure 88. Switch terminal connections.

WIRING HARNESS KEY

A Power Cord
B Limit Switch Harness
C Motor Harness

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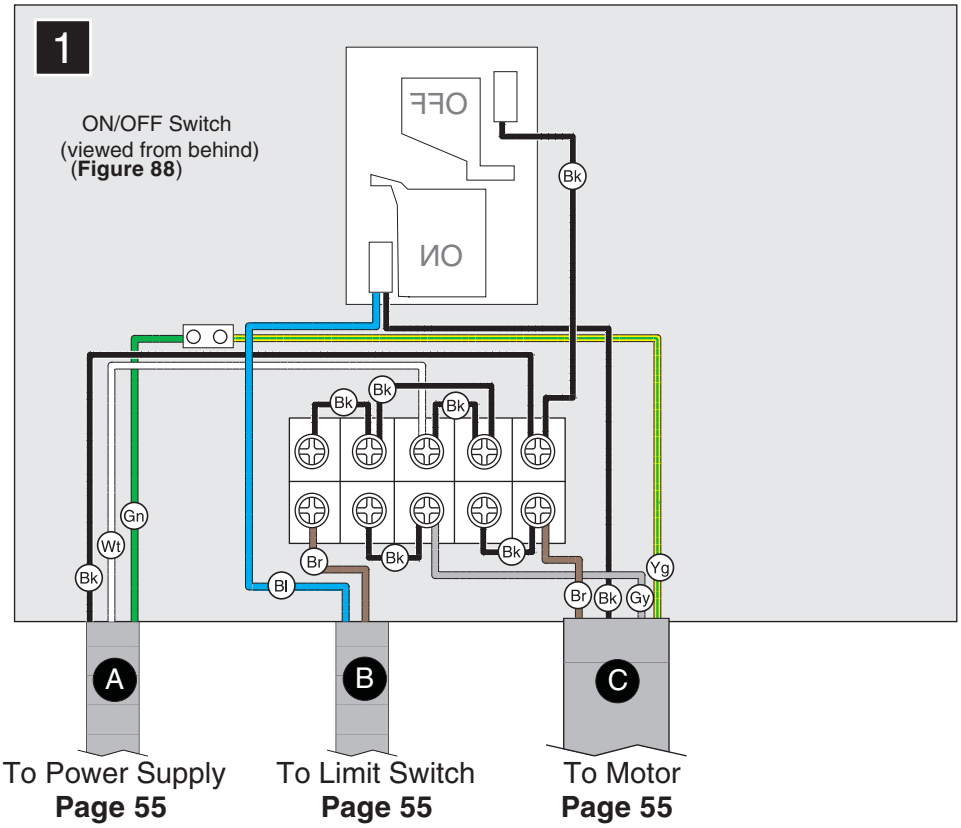


Figure 89. ON/OFF switch assembly wiring.

STOP ***READ ELECTRICAL SAFETY ON PAGE 52!***

Components Wiring

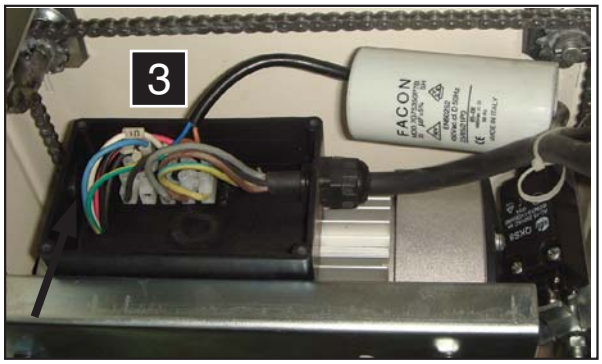
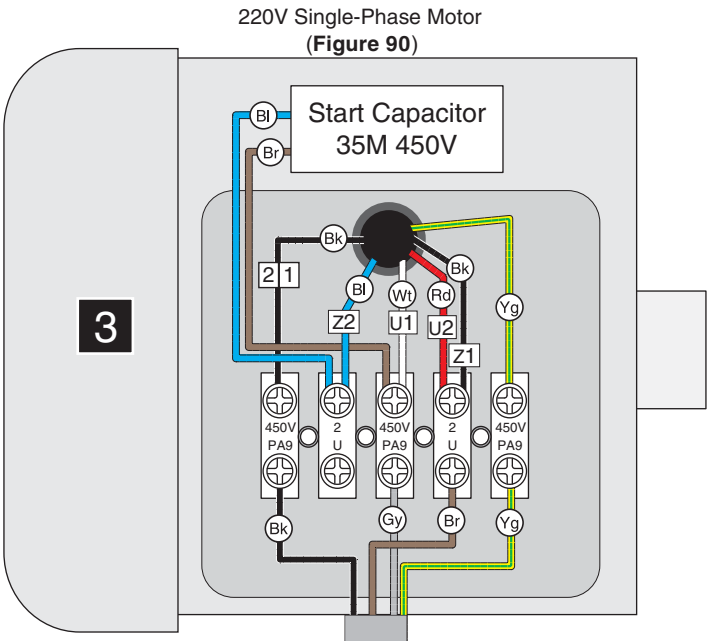


Figure 90. Motor wiring.



To ON/OFF Switch Box, **Page 54**

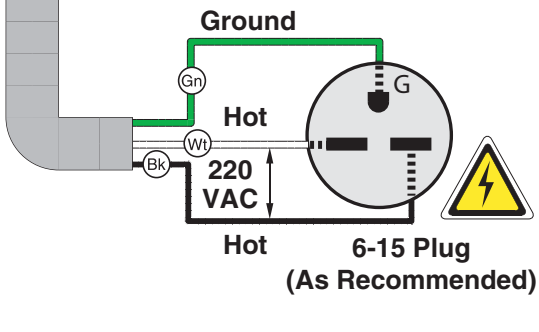
C

A

B

WIRING HARNESS KEY

- A Power Cord
- B Limit Switch Harness
- C Motor Harness



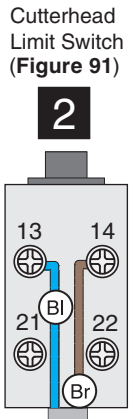
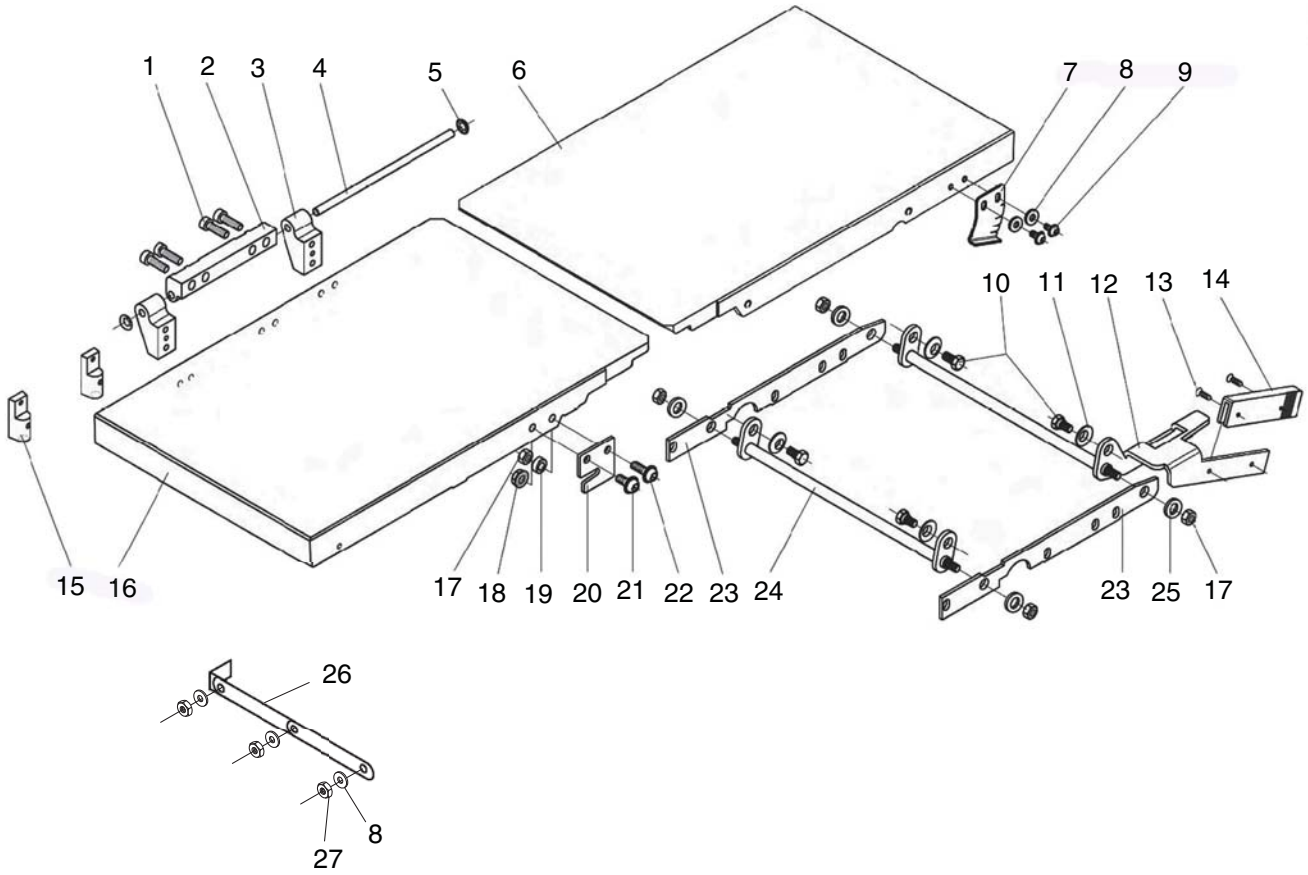


Figure 91. Limit switch.

SECTION 9: PARTS

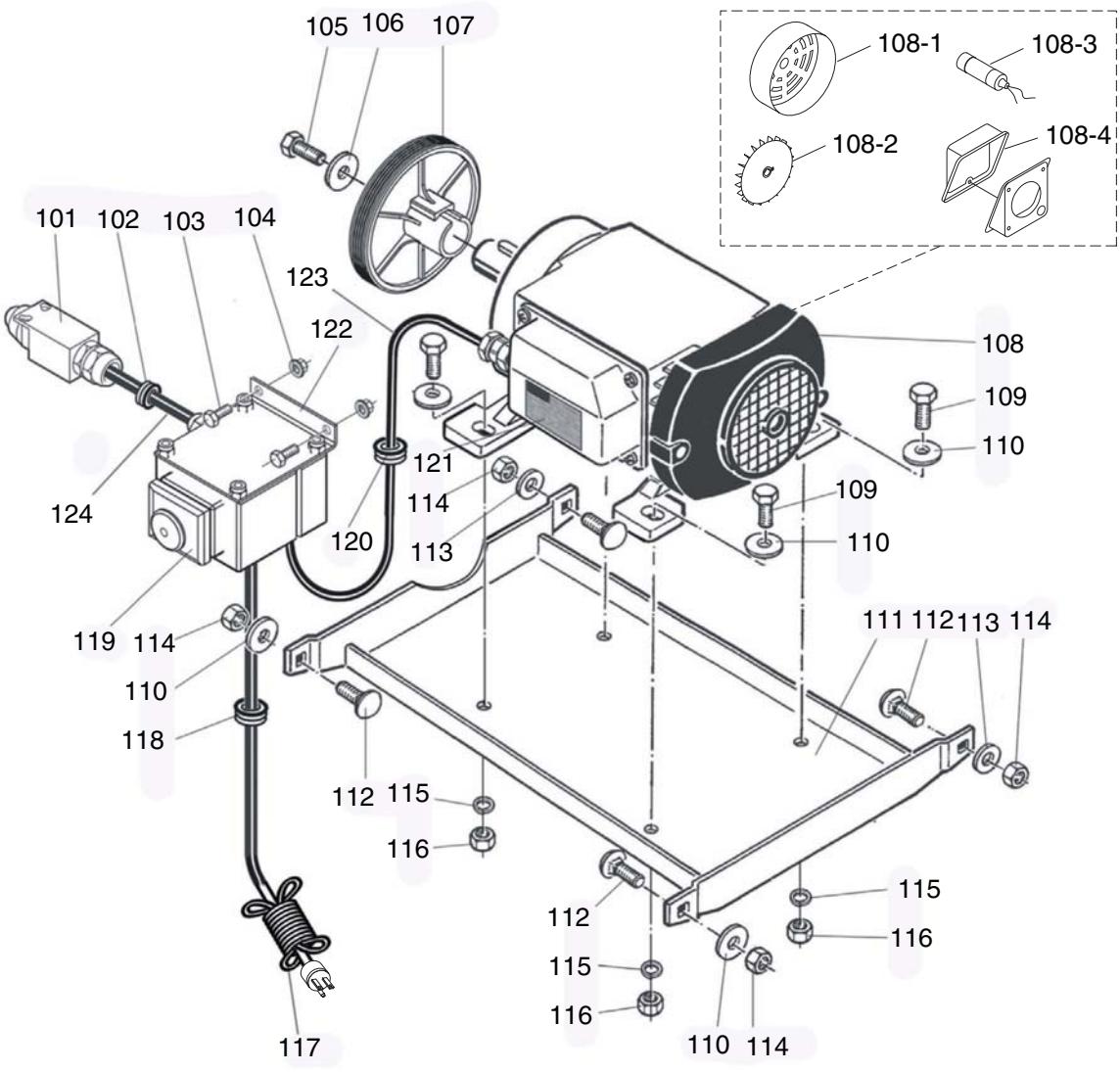
Table Breakdown



REF	PART #	DESCRIPTION
1	PSB13M	CAP SCREW M8-1.25 X 30
2	P0675002	TABLE SUPPORT BLOCK
3	P0675003	TABLE SUPPORT BRACKET
4	P0675004	BRACKET PIVOT SHAFT
5	P0675005	RETAINING RING
6	P0675006	INFEED TABLE
7	P0675007	INFEED TABLE INDICATOR
8	PW03M	FLAT WASHER 6MM
9	PS14M	PHLP HD SCR M6-1 X 12
10	P0675010	SPECIAL BOLT M8-1.25 X 14
11	PLW05M	LOCK WASHER 12MM
12	P0675012	INFEED TABLE LEVER
13	PSB33M	CAP SCREW M5-.8 X 12
14	P0675014	HANDLE COAT

REF	PART #	DESCRIPTION
15	P0675015	SUPPORT BLOCK
16	P0675016	OUTFEED TABLE
17	PLN04M	LOCK NUT M8-1.25
18	PFN01M	FLANGE NUT M8-1.25
19	P0675019	POSITIONING WASHER
20	P0675020	TABLE LOCKING PLATE
21	PSB11M	CAP SCREW M8-1.25 X 16
22	PSB31M	CAP SCREW M8-1.25 X 25
23	P0675023	TABLE HEIGHT SUPPORTER
24	P0675024	TABLE HEIGHT CONNECTOR
25	PW01M	FLAT WASHER 8MM
26	P0675026	LOCK ARM
27	PLN03M	LOCK NUT M6-1

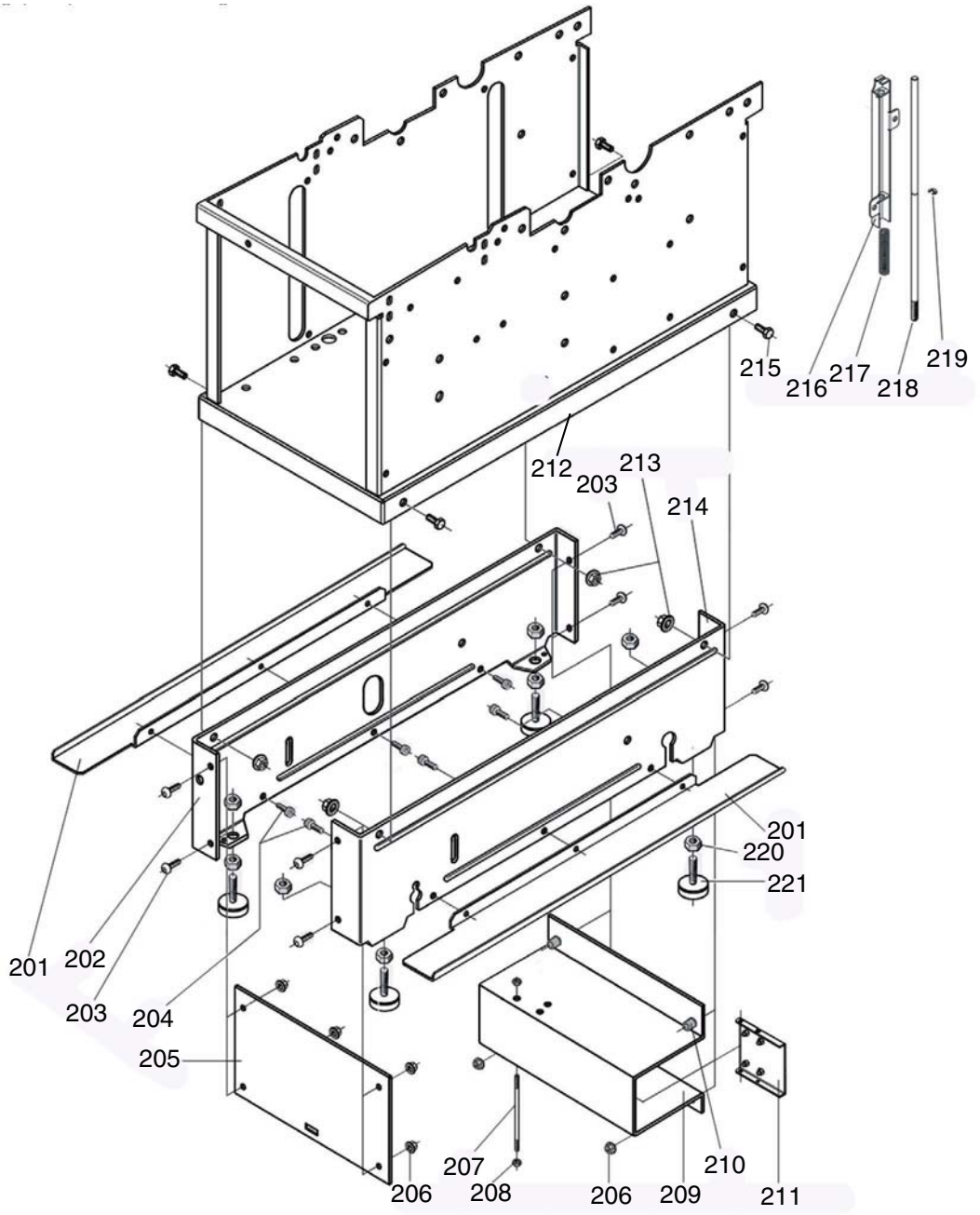
Motor Assembly Breakdown



REF	PART #	DESCRIPTION
101	P0675101	CUTTERHEAD LIMIT SWITCH
102	P0675102	CABLE SAFETY RING
103	PB02M	HEX BOLT M6-1 X 12
104	PFN02M	FLANGE NUT M6-1
105	PB07M	HEX BOLT M8-1.25 X 25
106	P0675106	SPECIAL WASHER 8MM
107	P0675107	MOTOR WHEEL
108	P0675108	MOTOR 2.4HP 220V SINGLE-PHASE
108-1	P0675108-1	MOTOR FAN COVER
108-2	P0675108-2	MOTOR FAN
108-3	P0675108-3	S CAPACITOR 35M 450V 1-3/4 x 3-3/4
108-4	P0675108-4	JUNCTION BOX
109	PB10M	HEX BOLT M6-1 X 25
110	PW01M	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
111	P0675111	MOTOR BRACKET
112	PCB06M	CARRIAGE BOLT M8-1.25 X 16
113	PW01M	FLAT WASHER 8MM
114	PLN04M	LOCK NUT M8-1.25
115	PLW04M	LOCK WASHER 8MM
116	PN03M	HEX NUT M8-1.25
117	P0675117	POWER CORD 14AWG X 3C
118	P0675118	RUBBER SAFETY RING
119	P0675119	SWITCH ASSEMBLY
120	P0675120	RUBBER SAFETY RING
121	P0675121	MOTOR LABEL
122	P0675122	SWITCH BRACKET
123	P0675123	MOTOR CORD
124	P0675124	LIMIT SWITCH CORD

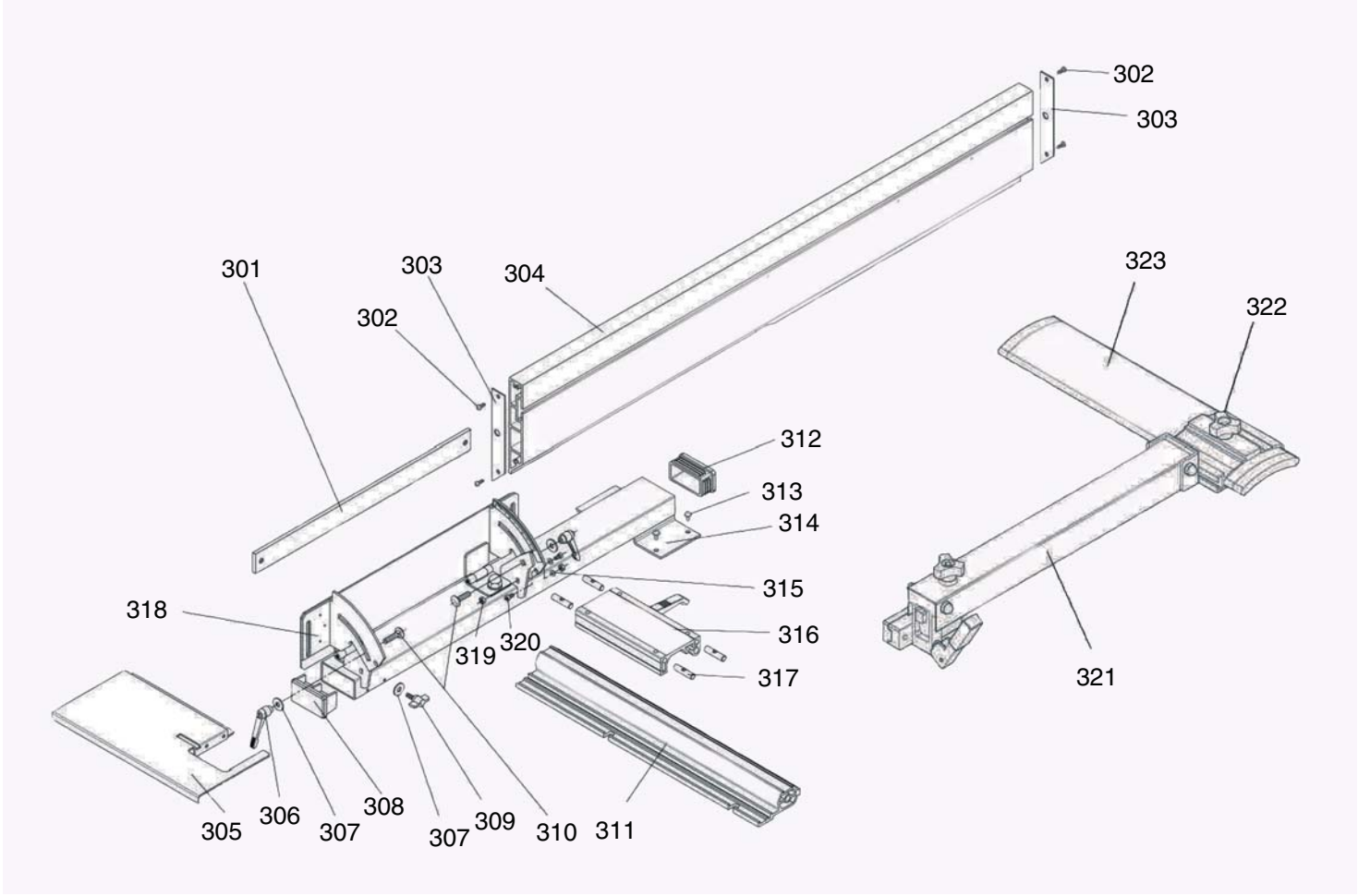
Frame Breakdown



REF	PART #	DESCRIPTION
201	P0675201	OUTSIDE BASE PLATE
202	P0675202	REAR BASE PLATE
203	PSBS09M	BUTTON HD CAP SCR M6-1 X 12
204	PSB01M	CAP SCREW M6-1 X 16
205	P0675205	MOTOR CASE PLATE
206	PLN03M	LOCK NUT M6-1
207	P0675207	PIVOT SHAFT
208	PLN03M	LOCK NUT M6-1
209	P0675209	CASE PLATE
210	P0675210	RIVET NUT M6-1 X 15
211	P0675211	PLATE

REF	PART #	DESCRIPTION
212	P0675212	FRAME
213	PFN01M	FLANGE NUT M8-1.25
214	P0675214	FRONT BASE PLATE
215	PB03M	HEX BOLT M8-1.25 X 16
216	P0675216	GUIDE BODY
217	P0675217	COMPRESSION SPRING
218	P0675218	SAFETY SWITCH ROD
219	PEC13M	E-CLIP 5MM
220	PN02M	HEX NUT M10-1.5
221	P0675221	FOOT SUPPORT M10-1.5

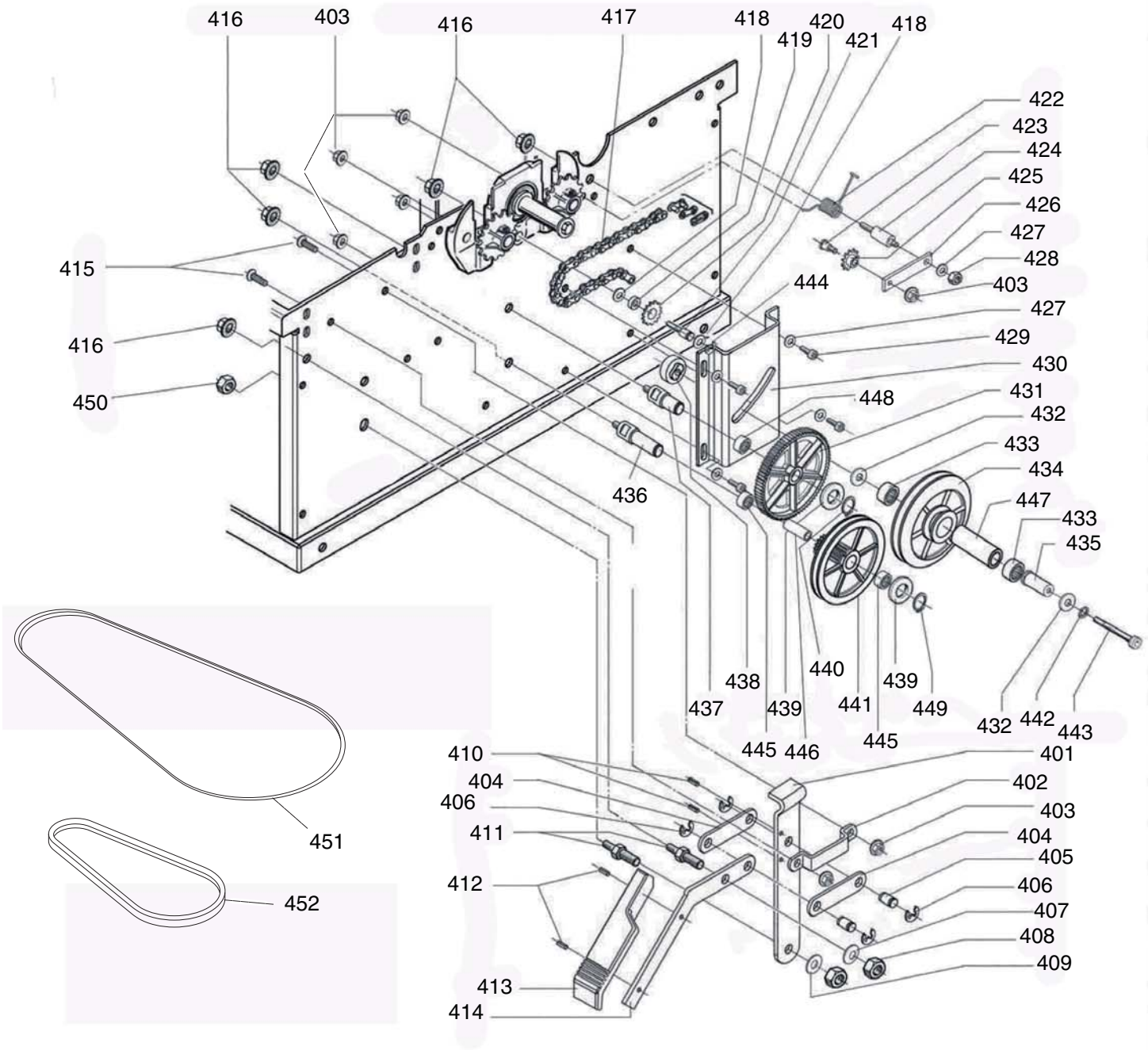
Fence Assembly Breakdown



REF	PART #	DESCRIPTION
301	P0675301	LOCKING INSERT PLATE
302	P0675302	TAP SCREW M4.8 X 12
303	P0675303	FENCE COVER
304	P0675304	FENCE
305	P0675305	GUARD PLATE
306	P0675306	TILT LEVER
307	PW03M	FLAT WASHER 6MM
308	P0675308	END PLUG
309	P0675309	WING SCREW M6-1
310	PCB22M	CARRIAGE BOLT M6-1 X 16
311	P0675311	RIP FENCE RAIL
312	P0675312	END PLUG

REF	PART #	DESCRIPTION
313	PB107M	HEX BOLT M5-.8 X 12
314	P0675314	RIP FENCE BRACKET
315	PW05M	FLAT WASHER 4MM
316	P0675316	HANDLE BRACKET
317	P0675317	ALIGNMENT SHAFT
318	P0675318	FENCE TILTING BRACKET
319	PN04M	HEX NUT M4-.7
320	PSB18M	CAP SCREW M4-.7 X 8
321	P0675321	BLADE GUARD BRACKET
322	P0675322	LOCK HANDLE M8-1.25 X 16
323	P0675323	BLADE GUARD COVER

Feed Gear Assembly Breakdown

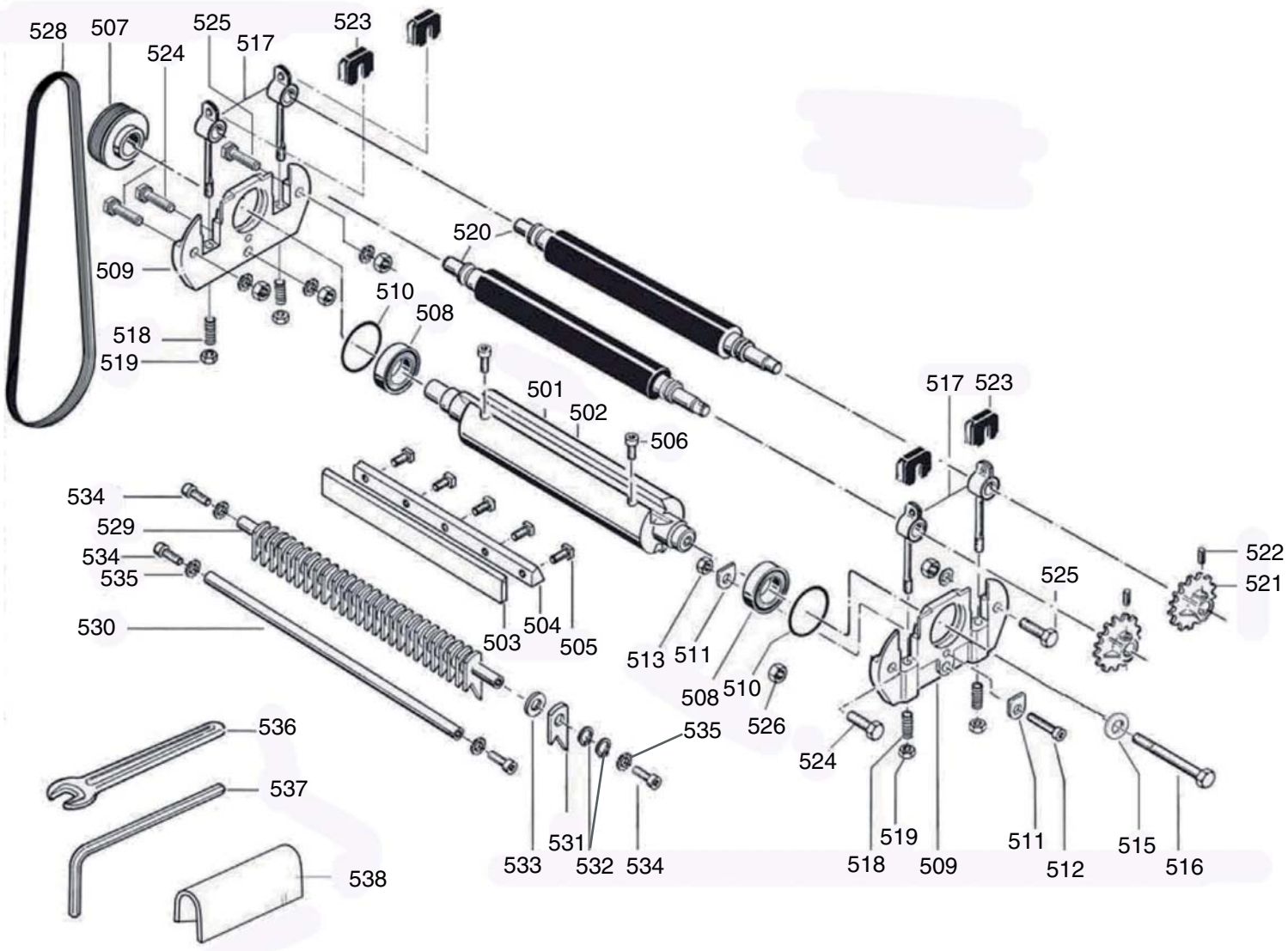


Feed Gear Assembly Parts List

REF	PART #	DESCRIPTION
401	P0675401	LOCKING PLATE
402	P0675402	POSITIONING PLATE
403	PFN01M	FLANGE NUT M8-1.25
404	P0675404	LOCKING CONNECTING PLATE
405	P0675405	ROTATING SHAFT
406	PEC015M	E-CLIP 8MM
407	PLW06M	LOCK WASHER 10MM
408	PLN05M	LOCK NUT M10-1.5
409	PW04M	FLAT WASHER 10MM
410	PRP78M	ROLL PIN 4 X 10
411	P0675411	SUPPORT SCREW
412	PRP78M	ROLL PIN 4 X 10
413	P0675413	LOCK HANDLE
414	P0675414	LOCK HANDLE SUPPORT
415	PFH02M	FLAT HD SCR M6-1 X 12
416	PFN01M	FLANGE NUT M8-1.25
417	P0675417	CHAIN
418	PW04M	FLAT WASHER 10MM
419	P0675419	NEEDLE BEARING 10 X 12 X 17
420	P0675420	TENSION SPROCKET
421	P0675421	POSITIONING SHAFT
422	P0675422	TORSION SPRING
423	P0675423	TENSION SHAFT
424	P0675424	SHAFT
425	P0675425	TENSION SPROCKET
426	P0675426	TENSION BRACKET

REF	PART #	DESCRIPTION
427	PW03M	FLAT WASHER 6MM
428	PLN03M	LOCK NUT M6-1
429	PSB02M	CAP SCREW M6-1 X 20
430	P0675430	WHEEL BRACKET
431	P0675431	SPROCKET WHEEL ASSEMBLY
432	P0675432	SPECIAL WASHER 8MM
433	P0675433	NEEDLE BEARING 14 X 12 X 20
434	P0675434	INFEED BELT WHEEL
435	P0675435	TUBE
436	P0675436	WHEEL SHAFT
437	P0675437	WHEEL SHAFT
438	P0675438	SLIDING BLOCK
439	PW08M	FLAT WASHER 16MM
440	PR06M	EXT RETAINING RING 16MM
441	P0675441	TOOTHED BELT WHEEL
442	PLW04M	LOCK WASHER 8MM
443	PSB128M	CAP SCREW M8-1.25 X 70
444	PEC015M	E-CLIP 8MM
445	P0675445	NEEDLE BEARING 12 X 10 X 16
446	P0675446	TUBE
447	P0675447	TUBE
448	P0675448	NEEDLE BEARING 16 X 16 X 22
449	PR03M	EXT RETAINING RING 12MM
450	PLN04M	LOCK NUT M8-1.25
451	P0675451	FLAT BELT 5/16" X 1/16" X 29"
452	P0675452	V-BELT K-20 5/16" X 1/4"

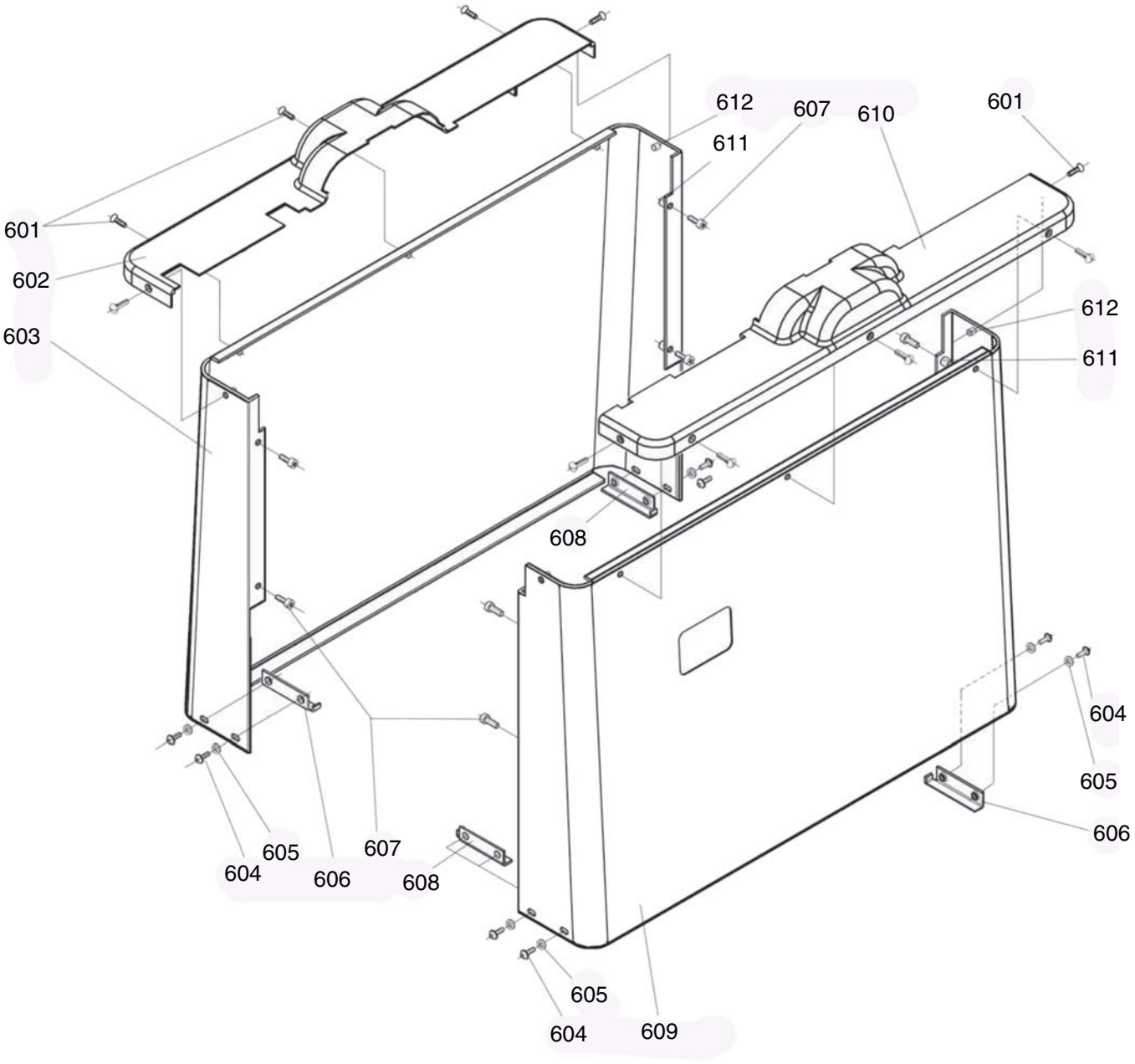
Cutterhead-Feed Rollers Breakdown



REF	PART #	DESCRIPTION
501	P0675501	CUTTERHEAD WITH KNIVES
502	P0675502	CUTTERHEAD
503	P0675503	KNIFE
504	P0675504	KNIFE GIB
505	P0675505	KNIFE GIB SCREW
506	P0675506	JACK SCREW
507	P0675507	CUTTERHEAD PULLEY
508	P6005	BALL BEARING 6005ZZ
509	P0675509	CUTTERBLOCK BRACKET
510	P0675510	O- RING
511	P0675511	BEARING CLAMP
512	PSB06M	CAP SCREW M6-1 X 25
513	PFN02M	FLANGE NUT M6-1
515	PW01M	FLAT WASHER 8MM
516	PB03M	HEX BOLT M8-1.25 X 16
517	P0675517	CLAMPING HOOP
518	P0675518	COMPRESSION SPRING
519	PLN03M	LOCK NUT M6-1

REF	PART #	DESCRIPTION
520	P0675520	FEED ROLLER
521	P0675521	SPROCKET WHEEL
522	PRP56M	ROLL PIN 4 X 25
523	P0675523	HOOP COVER
524	PB07M	HEX BOLT M8-1.25 X 25
525	PB26M	HEX BOLT M8-1.25 X 30
526	PFN01M	FLANGE NUT M8-1.25
528	P0675528	V-BELT A-40 4L520
529	P0675529	ANTI-KICKBACK SHAFT
530	P0675530	POSITIONING SHAFT
531	P0675531	ANTI-KICKBACK FINGER
532	PR39M	EXT RETAINING RING 8MM
533	PW04M	FLAT WASHER 10MM
534	PSB01M	CAP SCREW M6-1 X 16
535	PTLW05M	EXT TOOTH WASHER 6MM
536	PWR810	WRENCH 8/10
537	PAW05M	HEX WRENCH 5MM
538	P0675538	KNIFE SETTING GAUGE

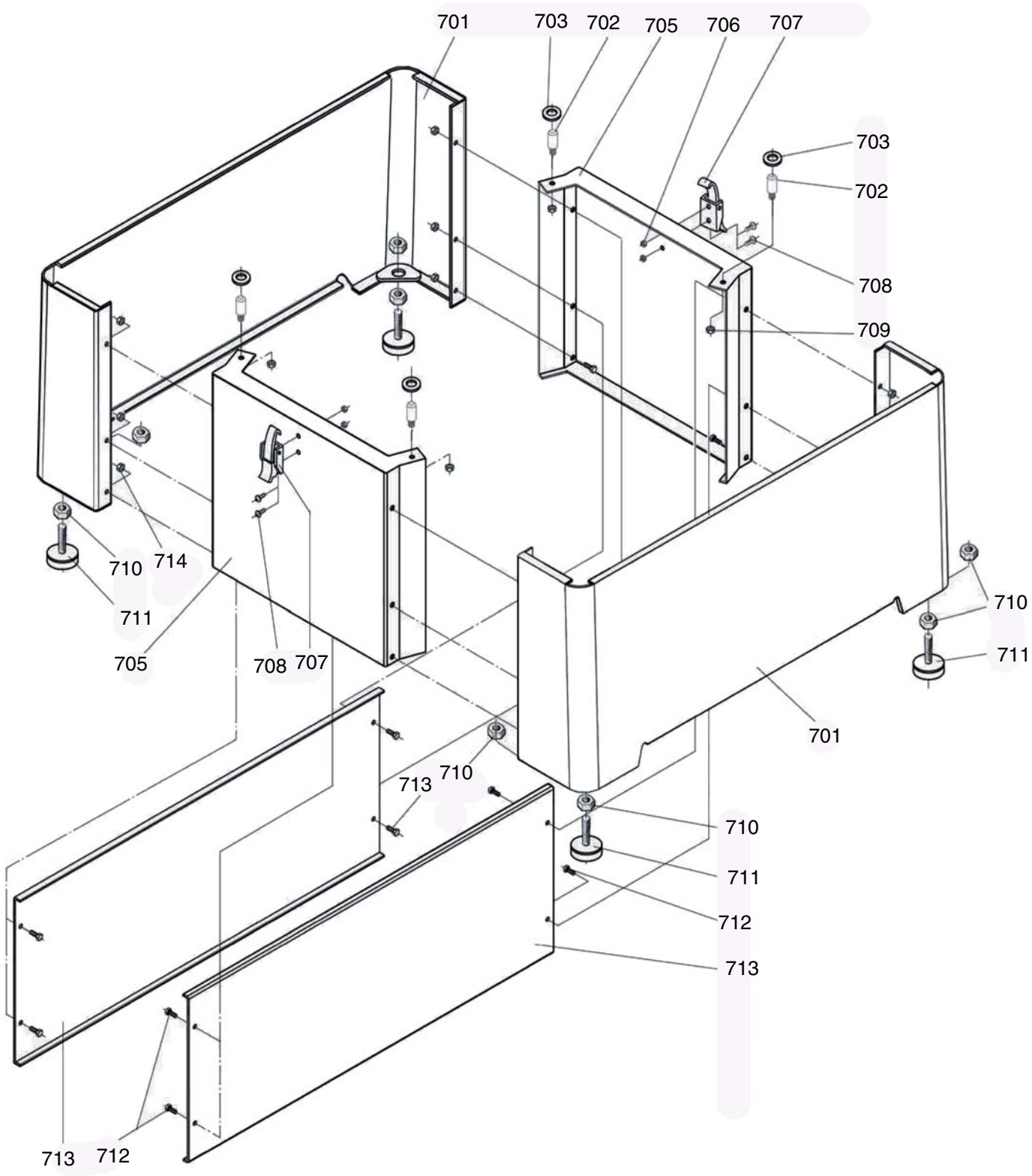
Access Panels Breakdown



REF	PART #	DESCRIPTION
601	PS40M	PHLP HD SCR M5-.8 X 16
602	P0675602	RIGHT UPPER COVER
603	P0675603	RIGHT ACCESS PANEL
604	PSBS11M	BUTTON HD CAP SCR M6-1 X 10
605	PW03M	FLAT WASHER 6MM
606	P0675606	COVER BRACKET

REF	PART #	DESCRIPTION
607	PSB01M	CAP SCREW M6-1 X 16
608	P0675608	COVER BRACKET
609	P0675609	LEFT ACCESS PANEL
610	P0675610	LEFT UPPER COVER
611	P0675611	RIVET NUT M6-1 X 15
612	P0675612	FLAT HEAD RIVET NUT M5-.8 X 13

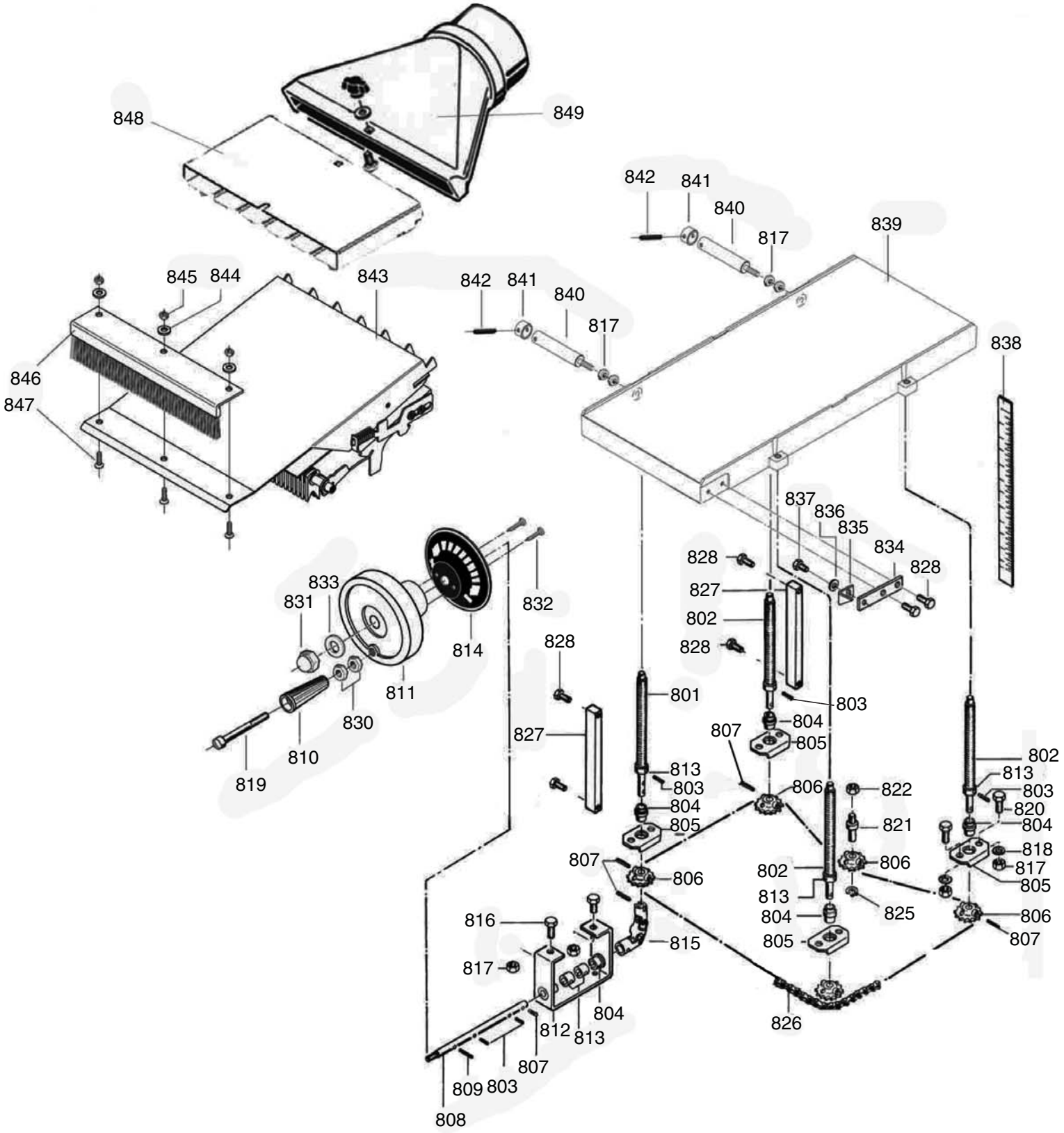
Base Breakdown



REF	PART #	DESCRIPTION
701	P0675701	BASE SIDE PANEL
702	P0675702	SPECIAL SCREW M6-1
703	P0675703	RUBBER WASHER 6MM
705	P0675705	BASE PANEL
706	PLN02M	LOCK NUT M5-.8
707	P0675707	CLAMPING HOOK
708	PS09M	PHLP HD SCR M5-.8 X 10

REF	PART #	DESCRIPTION
709	PLN03M	LOCK NUT M6-1
710	PN02M	HEX NUT M10-1.5
711	P0675711	FOOT M10-1.5
712	PB83M	HEX BOLT M6-1 X 16
713	P0675713	BASE SUPPORT PANEL
714	PN01M	HEX NUT M6-1

Planer Table Breakdown

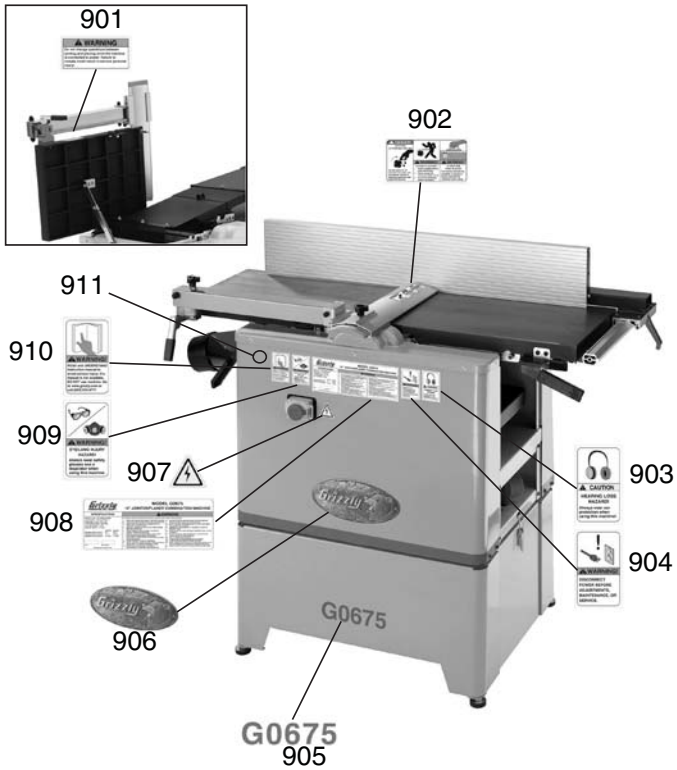


Planer Table Parts List

REF	PART #	DESCRIPTION
801	P0675801	ELEVATION LEADSCREW RL
802	P0675802	ELEVATION LEADSCREW
803	P0675803	ROLL PIN 4 X 6
804	P0675804	COPPER TUBE
805	P0675805	SUPPORT BRACKET
806	P0675806	LEADSCREW SPROCKET
807	PRP01M	ROLL PIN 4 X 18
808	P0675808	HANDWHEEL SHAFT
809	PRP39M	ROLL PIN 4 X 20
810	P0675810	PLASTIC HANDLE
811	P0675811	HANDWHEEL
812	P0675812	SADDLE BRACKET
813	P0675813	THREAD ROD TUBE
814	P0675814	HANDWHEEL SCALE
815	P0675815	LINKAGE
816	PB03M	HEX BOLT M8-1.25 X 16
817	PFN01M	FLANGE NUT M8-1.25
818	PW01M	FLAT WASHER 8MM
819	P0675819	HANDLE BOLT M10 X 1.5 X 98
820	PB03M	HEX BOLT M8-1.25 X 16
821	P0675821	ADJUSTING ROD
822	PLN04M	LOCK NUT M8-1.25
825	PEC03M	E-CLIP 10MM

REF	PART #	DESCRIPTION
826	P0675826	TABLE ELEVATION CHAIN
827	P0675827	PLANER TABLE GUIDE BLOCK
828	PB83M	HEX BOLT M6-1 X 16
830	PN02M	HEX NUT M10-1.5
831	PN43M	ACORN NUT M10-1.5
832	PHTEK22M	TAP SCREW M3.5 X 13
833	PW04M	FLAT WASHER 10MM
834	P0675834	INDICATOR BRACKET
835	P0675835	DEPTH SCALE INDICATOR
836	PW03M	FLAT WASHER 6MM
837	PB04M	HEX BOLT M6-1 X 10
838	P0675838	DEPTH SCALE
839	P0675839	THICKNESSING TABLE
840	P0675840	GUIDE AXLE
841	P0675841	BUSHING
842	P0675842	SPIRAL SPRING DOWEL SLEEVE
843	P0675843	DUST COLLECTOR ASSEMBLY
844	PW03M	FLAT WASHER 6MM
845	PLN03M	LOCK NUT M6-1
846	P0675846	BRUSH ASSEMBLY
847	P0675847	FLAT HD SCR M6-1 X 14
848	P0675848	DUST PORT BRACKET
849	P0675849	DUST PORT

Labels and Cosmetic Parts



REF	PART #	DESCRIPTION
901	P0675901	CHANGING OPERATIONS LABEL
902	PLABEL-29	CUTTERHEAD GUARD LABEL
903	PLABEL-15A	EAR PROTECTION LABEL
904	PLABEL-63	DISCONNECT POWER LABEL
905	P0675905	MODEL NUMBER LABEL
906	G8589	GRIZZLY NAMEPLATE-LARGE
907	PLABEL-14	ELECTRICITY LABEL
908	P0675908	MACHINE ID LABEL
909	PLABEL-57	GLASSES/RESPIRATOR LABEL
910	PLABEL-12A	READ MANUAL LABEL
911	PPAINT-11	GRIZZLY PUTTY TOUCH-UP PAINT

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinet Maker
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Modeltec
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Practical Homeowner
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend? _____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____ Yes _____ No

10. Comments: _____

_____

_____

_____

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GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
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Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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